

US009765249B2

(12) **United States Patent**  
**Braun et al.**

(10) **Patent No.:** **US 9,765,249 B2**  
(45) **Date of Patent:** **Sep. 19, 2017**

(54) **SHAPED ABRASIVE PARTICLE AND METHOD OF FORMING SAME**

(71) Applicant: **Saint-Gobain Ceramics & Plastics, Inc.**, Worcester, MA (US)

(72) Inventors: **Paul Braun**, Providence, RI (US); **Doruk O. Yener**, Wilmington, MA (US); **Jennifer H. Czerepinski**, Framingham, MA (US); **Ralph Bauer**, Niagara Falls (CA); **Krishnamoorthy Subramanian**, Lexington, MA (US); **Robin M. Bright**, Charlton, MA (US); **Anuj Seth**, Northborough, MA (US); **Gregory G. Lafond**, Boylston, MA (US)

(73) Assignee: **SAINT-GOBAIN CERAMICS & PLASTICS, INC.**, Worcester, MA (US)

(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 282 days.

(21) Appl. No.: **14/335,323**

(22) Filed: **Jul. 18, 2014**

(65) **Prior Publication Data**

US 2014/0325917 A1 Nov. 6, 2014

**Related U.S. Application Data**

(63) Continuation of application No. 13/731,810, filed on Dec. 31, 2012, now Pat. No. 8,840,695.  
(Continued)

(51) **Int. Cl.**  
**B24D 3/02** (2006.01)  
**C09C 1/68** (2006.01)  
(Continued)

(52) **U.S. Cl.**  
CPC ..... **C09K 3/1409** (2013.01); **B01J 2/22** (2013.01); **B01J 2/26** (2013.01); **C09C 1/24** (2013.01);  
(Continued)

(58) **Field of Classification Search**  
None  
See application file for complete search history.

(56) **References Cited**

U.S. PATENT DOCUMENTS

3,456,040 A 7/1886 Semper  
1,910,444 A 5/1933 Nicholson  
(Continued)

FOREIGN PATENT DOCUMENTS

CA 743715 A 10/1966  
CA 2423788 A1 7/2002  
(Continued)

OTHER PUBLICATIONS

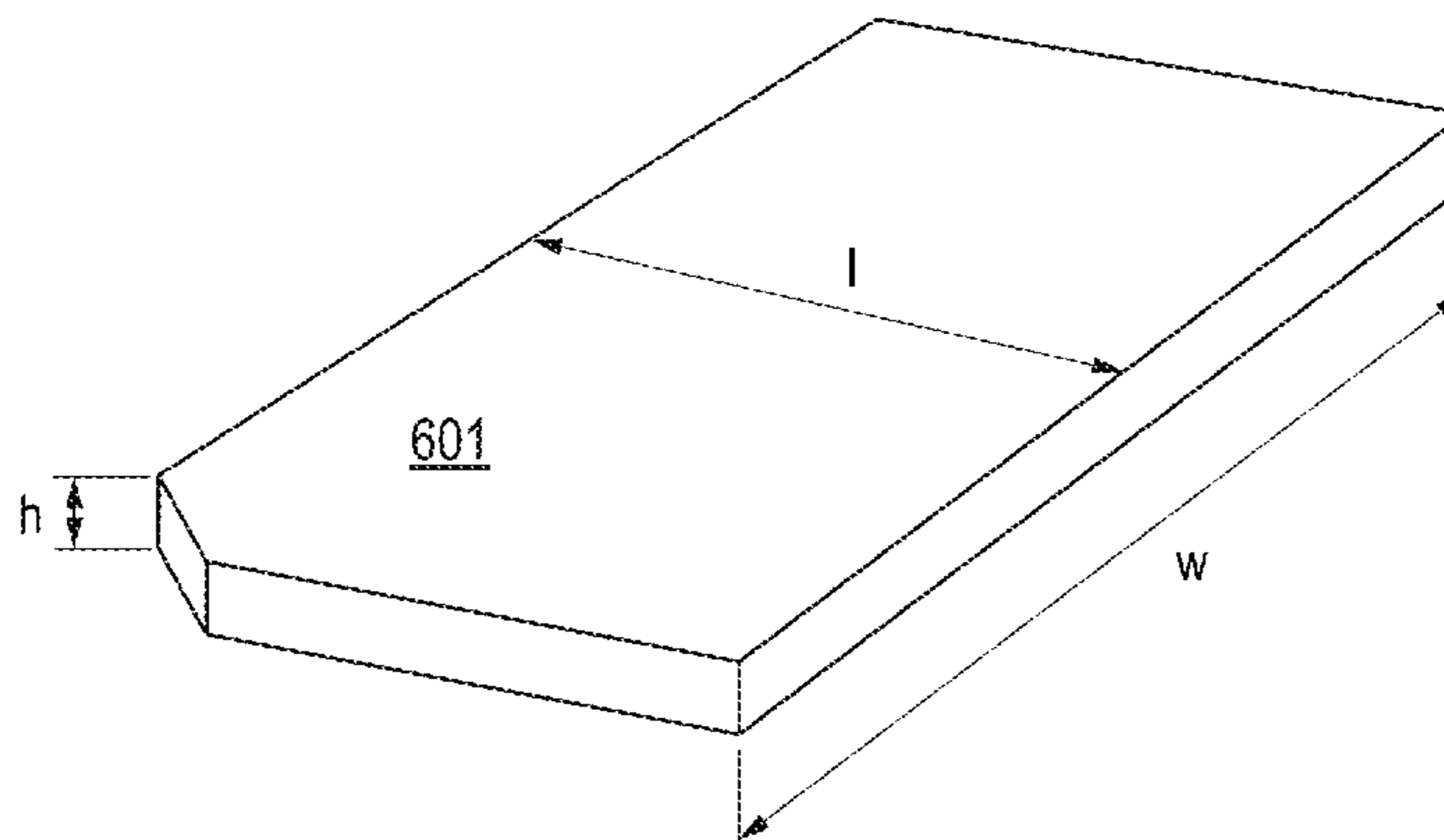
DOW Machine Tool Accessories, Grinding & Surface Finishing, www.lmta.com, Nov. 2014, 72 pages.  
(Continued)

*Primary Examiner* — Kaj K Olsen  
*Assistant Examiner* — Ross J Christie  
(74) *Attorney, Agent, or Firm* — Abel Law Group, LLP; Adam Keser

(57) **ABSTRACT**

A method of forming a mixture including a ceramic material into a sheet, sectioning at least a portion of the sheet using a mechanical object and forming at least one shaped abrasive particle from the sheet, such that the at least one shaped abrasive particle can have a two-dimensional shape as viewed in a plane defined by a length and a width of the shaped abrasive particle selected from the group consisting of polygons, ellipsoids, numerals, Greek alphabet characters, Latin alphabet characters, Russian alphabet characters, complex shapes having a combination of polygonal shapes, and a combination thereof.

**20 Claims, 16 Drawing Sheets**



<b>Related U.S. Application Data</b>					
(60)	Provisional application No. 61/581,800, filed on Dec. 30, 2011.		4,341,663 A	7/1982	Derleth et al.
			4,393,021 A	7/1983	Eisenberg et al.
			4,452,911 A	6/1984	Eccles et al.
			4,457,767 A	7/1984	Poon et al.
			4,469,758 A	9/1984	Scott
			4,505,720 A	3/1985	Gabor et al.
(51)	<b>Int. Cl.</b>		4,541,842 A	9/1985	Rostoker
	<i>C09K 3/14</i> (2006.01)		4,548,617 A	10/1985	Miyatani et al.
	<i>B01J 2/22</i> (2006.01)		4,570,048 A	2/1986	Poole
	<i>C09C 1/24</i> (2006.01)		4,618,349 A	10/1986	Hashimoto et al.
	<i>B01J 2/26</i> (2006.01)		4,623,364 A	11/1986	Cottringer et al.
	<i>C09C 1/40</i> (2006.01)		4,656,330 A	4/1987	Poole
(52)	<b>U.S. Cl.</b>		4,657,754 A	4/1987	Bauer et al.
	CPC ..... <i>C09C 1/407</i> (2013.01); <i>C09K 3/1436</i>		4,659,341 A	4/1987	Ludwig et al.
	(2013.01); <i>C01P 2004/39</i> (2013.01)		4,678,560 A	7/1987	Stole et al.
			4,711,750 A	12/1987	Scott
(56)	<b>References Cited</b>		4,728,043 A	3/1988	Ersdal et al.
	<b>U.S. PATENT DOCUMENTS</b>		4,744,802 A	5/1988	Schwabel
			4,770,671 A	9/1988	Monroe
			4,786,292 A	11/1988	Janz et al.
			4,797,139 A	1/1989	Bauer
			4,797,269 A	1/1989	Bauer et al.
			4,799,939 A	1/1989	Bloecher et al.
			4,829,027 A	5/1989	Cutler et al.
			4,832,706 A	5/1989	Yates
			4,848,041 A	7/1989	Kruschke
			4,858,527 A	8/1989	Masanao
			4,863,573 A	9/1989	Moore et al.
			4,876,226 A	10/1989	Fuentes
			4,881,951 A	11/1989	Wood et al.
			4,917,852 A	4/1990	Poole et al.
			4,918,116 A	4/1990	Gardziella et al.
			4,925,815 A	5/1990	Tani et al.
			4,930,266 A	6/1990	Calhoun et al.
			4,942,011 A	7/1990	Bolt et al.
			4,954,462 A	9/1990	Wood
			4,960,441 A	10/1990	Pellow et al.
			4,961,757 A	10/1990	Rhodes et al.
			4,963,012 A	10/1990	Tracy
			4,964,883 A	10/1990	Morris et al.
			4,970,057 A	11/1990	Willkens et al.
			4,997,461 A	3/1991	Markhoff-Matheny et al.
			5,009,675 A	4/1991	Kunz et al.
			5,009,676 A	4/1991	Rue et al.
			5,011,508 A	4/1991	Wald et al.
			5,011,510 A	4/1991	Hayakawa et al.
			5,014,468 A	5/1991	Ravipati et al.
			5,024,795 A	6/1991	Kennedy et al.
			5,032,304 A	7/1991	Toyota
			5,035,723 A	7/1991	Kalinowski et al.
			5,035,724 A	7/1991	Pukari et al.
			5,042,991 A	8/1991	Kunz et al.
			5,049,166 A	9/1991	Kirkendall
			5,049,645 A	9/1991	Nagaoka et al.
			5,053,367 A	10/1991	Newkirk et al.
			5,053,369 A	10/1991	Winkler et al.
			5,076,991 A	12/1991	Poole et al.
			5,078,753 A	1/1992	Broberg et al.
			5,081,082 A	1/1992	Hai-Doo et al.
			5,085,671 A	2/1992	Martin et al.
			5,090,968 A	2/1992	Pellow
			5,094,986 A	3/1992	Matsumoto et al.
			5,098,740 A	3/1992	Tewari
			5,103,598 A	4/1992	Kelly
			5,108,963 A	4/1992	Fu et al.
			5,114,438 A	5/1992	Leatherman et al.
			5,120,327 A	6/1992	Dennis
			5,123,935 A	6/1992	Kanamaru et al.
			5,129,919 A	7/1992	Kalinowski et al.
			5,131,926 A	7/1992	Rostoker et al.
			5,132,984 A	7/1992	Simpson
			5,139,978 A	8/1992	Wood
			5,152,917 A	10/1992	Pieper et al.
			5,160,509 A	11/1992	Carman et al.
			5,164,744 A	11/1992	Yoshida et al.
			5,173,457 A	12/1992	Shorthouse
			5,178,849 A	1/1993	Bauer
			5,180,630 A	1/1993	Giglia
			5,185,012 A	2/1993	Kelly



(56)

## References Cited

## U.S. PATENT DOCUMENTS

5,185,299 A	2/1993	Wood et al.	5,645,619 A	7/1997	Erickson et al.
5,190,568 A	3/1993	Tselesin	5,651,925 A	7/1997	Ashley et al.
5,194,072 A	3/1993	Rue et al.	5,656,217 A	8/1997	Rogers et al.
5,201,916 A	4/1993	Berg et al.	5,667,542 A	9/1997	Law et al.
5,203,886 A	4/1993	Sheldon et al.	5,669,941 A	9/1997	Peterson
5,213,591 A	5/1993	Celikkaya et al.	5,669,943 A	9/1997	Horton et al.
5,215,552 A	6/1993	Sung	5,672,097 A	9/1997	Hoopman
5,219,462 A	6/1993	Bruxvoort et al.	5,672,554 A	9/1997	Mohri et al.
5,219,806 A	6/1993	Wood	5,683,844 A	11/1997	Mammino
5,221,294 A	6/1993	Carman et al.	5,702,811 A	12/1997	Ho et al.
5,224,970 A	7/1993	Harakawa et al.	5,725,162 A	3/1998	Garg et al.
5,227,104 A	7/1993	Bauer	5,736,619 A	4/1998	Kane et al.
5,244,477 A	9/1993	Rue et al.	5,738,696 A	4/1998	Wu
5,244,849 A	9/1993	Roy et al.	5,738,697 A	4/1998	Wu et al.
5,273,558 A	12/1993	Nelson et al.	5,751,313 A	5/1998	Miyashita et al.
5,277,702 A	1/1994	Thibault et al.	5,759,481 A	6/1998	Pujari et al.
5,282,875 A	2/1994	Wood	5,776,214 A	7/1998	Wood
5,288,297 A	2/1994	Ringwood	5,779,743 A	7/1998	Wood
5,300,130 A	4/1994	Rostoker	5,785,722 A	7/1998	Garg et al.
5,304,331 A	4/1994	Leonard et al.	5,810,587 A	9/1998	Bruns et al.
5,312,789 A	5/1994	Wood	5,820,450 A	10/1998	Calhoun
5,312,791 A	5/1994	Coblentz et al.	5,830,248 A	11/1998	Christianson et al.
5,366,523 A	11/1994	Rowenhorst et al.	5,840,089 A	11/1998	Chesley et al.
5,366,525 A	11/1994	Fujiyama	5,849,646 A	12/1998	Stout et al.
5,372,620 A	12/1994	Rowse et al.	5,855,997 A	1/1999	Amateau
5,373,786 A	12/1994	Umaba	5,863,306 A	1/1999	Wei et al.
5,376,598 A	12/1994	Preedy et al.	5,866,254 A	2/1999	Peker et al.
5,376,602 A	12/1994	Nilsen	5,876,793 A	3/1999	Sherman et al.
5,383,945 A	1/1995	Cottringer et al.	5,885,311 A	3/1999	McCutcheon et al.
5,395,407 A	3/1995	Cottringer et al.	5,893,935 A	4/1999	Wood
5,409,645 A	4/1995	Torre, Jr. et al.	5,902,647 A	5/1999	Venkataramani
5,429,648 A	7/1995	Wu	5,908,477 A	6/1999	Harmer et al.
5,431,967 A	7/1995	Manthiram	5,908,478 A	6/1999	Wood
5,435,816 A	7/1995	Spurgeon et al.	5,919,549 A	7/1999	Van et al.
5,437,754 A	8/1995	Calhoun	5,924,917 A	7/1999	Benedict et al.
5,441,549 A	8/1995	Helmin	5,942,015 A	8/1999	Culler et al.
5,443,603 A	8/1995	Kirkendall	5,946,991 A	9/1999	Hoopman
5,447,894 A	9/1995	Yasuoka et al.	5,975,987 A	11/1999	Hoopman et al.
5,453,106 A	9/1995	Roberts	5,980,678 A	11/1999	Tselesin
5,454,844 A	10/1995	Hibbard et al.	5,984,988 A	11/1999	Berg et al.
5,470,806 A	11/1995	Krstic et al.	5,989,301 A	11/1999	Laconto, Sr. et al.
5,479,873 A	1/1996	Shintani et al.	5,997,597 A	12/1999	Hagan
5,482,756 A	1/1996	Berger et al.	6,016,660 A	1/2000	Abramshe
5,486,496 A	1/1996	Talbert et al.	6,019,805 A	2/2000	Herron
5,496,386 A	3/1996	Broberg et al.	6,024,824 A	2/2000	Krech
5,500,273 A	3/1996	Holmes et al.	6,027,326 A	2/2000	Cesarano, III et al.
5,514,631 A	5/1996	Cottringer et al.	6,048,577 A	4/2000	Garg
5,516,347 A	5/1996	Garg	6,053,956 A	4/2000	Wood
5,516,348 A	5/1996	Conwell et al.	6,054,093 A	4/2000	Torre, Jr. et al.
5,523,074 A	6/1996	Takahashi et al.	6,080,215 A	6/2000	Stubbs et al.
5,525,100 A	6/1996	Kelly et al.	6,080,216 A	6/2000	Erickson
5,527,369 A	6/1996	Garg	6,083,622 A	7/2000	Garg et al.
5,543,368 A	8/1996	Talbert et al.	6,096,107 A	8/2000	Caracostas et al.
5,551,963 A	9/1996	Larmie	6,110,241 A	8/2000	Sung
5,560,745 A	10/1996	Roberts	6,129,540 A	10/2000	Hoopman et al.
5,567,150 A	10/1996	Conwell et al.	6,136,288 A	10/2000	Bauer et al.
5,567,214 A	10/1996	Ashley	6,146,247 A	11/2000	Nokubi et al.
5,567,251 A	10/1996	Peker et al.	6,179,887 B1	1/2001	Barber, Jr. et al.
5,571,297 A	11/1996	Swei et al.	6,206,942 B1	3/2001	Wood
5,576,409 A	11/1996	Mackey	6,228,134 B1	5/2001	Erickson
5,578,095 A	11/1996	Bland et al.	6,238,450 B1	5/2001	Garg et al.
5,578,222 A	11/1996	Trischuk et al.	6,258,137 B1	7/2001	Garg et al.
5,582,625 A	12/1996	Wright et al.	6,258,141 B1	7/2001	Sung et al.
5,584,896 A	12/1996	Broberg et al.	6,261,682 B1	7/2001	Law
5,584,897 A	12/1996	Christianson et al.	6,264,710 B1	7/2001	Erickson
5,591,685 A	1/1997	Mitomo et al.	6,277,160 B1	8/2001	Stubbs et al.
5,593,468 A	1/1997	Khaund et al.	6,277,161 B1	8/2001	Castro et al.
5,599,493 A	2/1997	Ito et al.	6,283,997 B1	9/2001	Garg et al.
5,603,738 A	2/1997	Zeiringer et al.	6,284,690 B1	9/2001	Nakahata et al.
5,609,706 A	3/1997	Benedict et al.	6,287,353 B1	9/2001	Celikkaya
5,611,829 A	3/1997	Monroe et al.	6,306,007 B1	10/2001	Mori et al.
5,618,221 A	4/1997	Furukawa et al.	6,312,324 B1	11/2001	Mitsui et al.
5,628,952 A	5/1997	Holmes et al.	6,319,108 B1	11/2001	Adefris et al.
5,641,469 A	6/1997	Garg et al.	6,331,343 B1	12/2001	Perez et al.
RE35,570 E	7/1997	Rowenhorst et al.	6,371,842 B1	4/2002	Romero
			6,391,812 B1	5/2002	Araki et al.
			6,401,795 B1	6/2002	Cesarano, III et al.
			6,403,001 B1	6/2002	Hayashi
			6,413,286 B1	7/2002	Swei et al.



(56)

References Cited

U.S. PATENT DOCUMENTS

6,451,076 B1	9/2002	Nevoret et al.	8,470,759 B2	6/2013	Gonzales et al.
6,475,253 B2	11/2002	Culler et al.	8,480,772 B2	7/2013	Welygan et al.
6,524,681 B1	2/2003	Seitz et al.	8,628,597 B2	1/2014	Palmgren et al.
6,531,423 B1	3/2003	Schwetz et al.	8,783,589 B2	7/2014	Hart et al.
6,537,140 B1	3/2003	Miller et al.	8,852,643 B2	10/2014	Gonzales et al.
6,579,819 B2	6/2003	Hirosaki et al.	9,017,439 B2	4/2015	Yener et al.
6,582,623 B1	6/2003	Grumbine et al.	2001/0027623 A1	10/2001	Rosenflanz
6,583,080 B1	6/2003	Rosenflanz	2002/0026752 A1	3/2002	Culler et al.
6,599,177 B2	7/2003	Nevoret et al.	2002/0151265 A1	10/2002	Adefris
6,646,019 B2	11/2003	Perez et al.	2002/0170236 A1	11/2002	Larson et al.
6,652,361 B1	11/2003	Gash et al.	2002/0174935 A1	11/2002	Burdon et al.
6,669,745 B2	12/2003	Prichard et al.	2002/0177391 A1	11/2002	Fritz et al.
6,685,755 B2	2/2004	Ramanath et al.	2003/0008933 A1	1/2003	Perez et al.
6,696,258 B1	2/2004	Wei	2003/0022961 A1	1/2003	Kusaka et al.
6,702,650 B2	3/2004	Adefris	2003/0029094 A1	2/2003	Moeltgen et al.
6,737,378 B2	5/2004	Hirosaki et al.	2003/0085204 A1	5/2003	Lagos
6,749,496 B2	6/2004	Mota et al.	2003/0109371 A1	6/2003	Pujari et al.
6,755,729 B2	6/2004	Ramanath et al.	2003/0110707 A1	6/2003	Rosenflanz et al.
6,833,014 B2	12/2004	Welygan et al.	2003/0126800 A1	7/2003	Seth et al.
6,843,815 B1	1/2005	Thurber et al.	2004/0003895 A1	1/2004	Amano et al.
6,846,795 B2	1/2005	Lant et al.	2004/0148868 A1	8/2004	Anderson et al.
6,878,456 B2	4/2005	Castro et al.	2004/0148967 A1	8/2004	Celikkaya et al.
6,881,483 B2	4/2005	McArdle et al.	2004/0202844 A1	10/2004	Wong
6,888,360 B1	5/2005	Connell et al.	2004/0224125 A1	11/2004	Yamada et al.
6,913,824 B2	7/2005	Culler et al.	2004/0235406 A1	11/2004	Duescher
6,942,561 B2	9/2005	Mota et al.	2004/0244675 A1	12/2004	Kishimoto et al.
6,949,128 B2	9/2005	Annen	2005/0020190 A1	1/2005	Schutz et al.
6,951,504 B2 *	10/2005	Adefris ..... B24B 1/00 428/570	2005/0060941 A1	3/2005	Provow et al.
6,974,930 B2	12/2005	Jense	2005/0060947 A1	3/2005	McArdle et al.
7,022,179 B1	4/2006	Dry	2005/0064805 A1	3/2005	Culler et al.
7,044,989 B2	5/2006	Welygan et al.	2005/0081455 A1	4/2005	Welygan et al.
7,141,522 B2	11/2006	Rosenflanz et al.	2005/0118939 A1	6/2005	Duescher
7,168,267 B2	1/2007	Rosenflanz et al.	2005/0132655 A1	6/2005	Anderson et al.
7,169,198 B2	1/2007	Moeltgen et al.	2005/0218565 A1	10/2005	DiChiara, Jr.
7,267,700 B2	9/2007	Collins et al.	2005/0223649 A1	10/2005	O'Gary et al.
7,294,158 B2	11/2007	Welygan et al.	2005/0232853 A1	10/2005	Evans et al.
7,297,170 B2	11/2007	Welygan et al.	2005/0245179 A1	11/2005	Luedeke
7,297,402 B2	11/2007	Evans et al.	2005/0255801 A1	11/2005	Pollasky
7,364,788 B2	4/2008	Kishbaugh et al.	2005/0266221 A1	12/2005	Karam et al.
7,373,887 B2	5/2008	Jackson	2005/0271795 A1	12/2005	Moini et al.
7,384,437 B2	6/2008	Welygan et al.	2005/0284029 A1	12/2005	Bourlier et al.
7,488,544 B2	2/2009	Schofalvi et al.	2006/0049540 A1	3/2006	Hui et al.
7,507,268 B2	3/2009	Rosenflanz	2006/0126265 A1	6/2006	Crespi et al.
7,553,346 B2	6/2009	Welygan et al.	2006/0135050 A1	6/2006	Petersen et al.
7,556,558 B2	7/2009	Palmgren	2006/0177488 A1	8/2006	Caruso et al.
7,560,062 B2	7/2009	Gould et al.	2006/0185256 A1	8/2006	Nevoret et al.
7,560,139 B2	7/2009	Thebault et al.	2007/0020457 A1	1/2007	Adefris
7,563,293 B2	7/2009	Rosenflanz	2007/0051355 A1	3/2007	Sung
7,611,795 B2	11/2009	Aoyama et al.	2007/0072527 A1	3/2007	Palmgren
7,618,684 B2	11/2009	Nesbitt	2007/0074456 A1	4/2007	Orlhac et al.
7,662,735 B2	2/2010	Rosenflanz et al.	2007/0087928 A1	4/2007	Rosenflanz et al.
7,666,344 B2	2/2010	Schofalvi et al.	2007/0234646 A1	10/2007	Can et al.
7,666,475 B2	2/2010	Morrison	2008/0017053 A1	1/2008	Araumi et al.
7,669,658 B2	3/2010	Barron et al.	2008/0121124 A1	5/2008	Sato
7,670,679 B2	3/2010	Krishna et al.	2008/0172951 A1	7/2008	Starling
7,695,542 B2	4/2010	Drivdahl et al.	2008/0176075 A1	7/2008	Bauer et al.
7,858,189 B2	12/2010	Wagener et al.	2008/0179783 A1	7/2008	Liu et al.
7,906,057 B2	3/2011	Zhang et al.	2008/0230951 A1	9/2008	Dannoux et al.
7,968,147 B2	6/2011	Fang et al.	2008/0233845 A1 *	9/2008	Annen ..... B24D 9/08 451/259
7,972,430 B2	7/2011	Millard et al.	2008/0262577 A1	10/2008	Altshuler et al.
8,021,449 B2	9/2011	Seth et al.	2008/0286590 A1	11/2008	Besida et al.
8,034,137 B2	10/2011	Erickson et al.	2008/0299875 A1	12/2008	Duescher
8,049,136 B2	11/2011	Mase et al.	2009/0016916 A1	1/2009	Rosenzweig et al.
8,070,556 B2	12/2011	Kumar et al.	2009/0017736 A1	1/2009	Block et al.
8,123,828 B2	2/2012	Culler et al.	2009/0165394 A1	7/2009	Culler et al.
8,141,484 B2	3/2012	Ojima et al.	2009/0165661 A1	7/2009	Koenig et al.
8,142,531 B2	3/2012	Adefris et al.	2009/0169816 A1	7/2009	Erickson et al.
8,142,532 B2	3/2012	Erickson et al.	2009/0208734 A1	8/2009	Macfie et al.
8,142,891 B2	3/2012	Culler et al.	2009/0215366 A1	8/2009	Ishizuka
8,251,774 B2	8/2012	Joseph et al.	2009/0246464 A1	10/2009	Watanabe et al.
8,256,091 B2	9/2012	Duescher	2010/0000159 A1	1/2010	Walia et al.
8,440,602 B2	5/2013	Gonzales et al.	2010/0003900 A1	1/2010	Sakaguchi et al.
8,440,603 B2	5/2013	Gonzales et al.	2010/0003904 A1	1/2010	Duescher
8,445,422 B2	5/2013	Gonzales et al.	2010/0056816 A1	3/2010	Wallin et al.
			2010/0064594 A1	3/2010	Pakalapati et al.
			2010/0068974 A1	3/2010	Dumm
			2010/0146867 A1	6/2010	Boden et al.
			2010/0151195 A1	6/2010	Culler et al.



(56)

References Cited

U.S. PATENT DOCUMENTS

2010/0151196 A1 6/2010 Adefris et al.  
 2010/0151201 A1 6/2010 Erickson et al.  
 2010/0190424 A1 7/2010 Francois et al.  
 2010/0201018 A1 8/2010 Yoshioka et al.  
 2010/0292428 A1 11/2010 Meador et al.  
 2010/0307067 A1 12/2010 Sigalas et al.  
 2010/0319269 A1 12/2010 Erickson  
 2011/0008604 A1 1/2011 Boylan  
 2011/0111563 A1 5/2011 Yanagi et al.  
 2011/0124483 A1 5/2011 Shah et al.  
 2011/0136659 A1 6/2011 Allen et al.  
 2011/0146509 A1 6/2011 Welygan et al.  
 2011/0160104 A1 6/2011 Wu et al.  
 2011/0244769 A1 10/2011 David et al.  
 2011/0289854 A1 12/2011 Moren et al.  
 2011/0314746 A1 12/2011 Erickson et al.  
 2012/0000135 A1 1/2012 Eilers et al.  
 2012/0055098 A1 3/2012 Ramanath et al.  
 2012/0137597 A1 6/2012 Adefris et al.  
 2012/0144754 A1 6/2012 Culler et al.  
 2012/0144755 A1 6/2012 Erickson et al.  
 2012/0153547 A1 6/2012 Bauer et al.  
 2012/0167481 A1 7/2012 Yener et al.  
 2012/0168979 A1 7/2012 Bauer et al.  
 2012/0227333 A1 9/2012 Adefris et al.  
 2012/0231711 A1\* 9/2012 Keipert ..... C09K 3/1409  
 451/534  
 2013/0000212 A1 1/2013 Wang et al.  
 2013/0000216 A1 1/2013 Wang et al.  
 2013/0009484 A1 1/2013 Yu  
 2013/0036402 A1 2/2013 Mutisya et al.  
 2013/0040537 A1\* 2/2013 Schwabel ..... B24D 5/04  
 451/28  
 2013/0045251 A1 2/2013 Cen et al.  
 2013/0067669 A1 3/2013 Gonzales et al.  
 2013/0072417 A1 3/2013 Perez-Prat et al.  
 2013/0074418 A1 3/2013 Panzarella et al.  
 2013/0125477 A1 5/2013 Adefris  
 2013/0180180 A1 7/2013 Yener et al.  
 2013/0186005 A1 7/2013 Kavanaugh  
 2013/0186006 A1 7/2013 Kavanaugh et al.  
 2013/0199105 A1 8/2013 Braun et al.  
 2013/0212952 A1 8/2013 Welygan et al.  
 2013/0236725 A1 9/2013 Yener et al.  
 2013/0255162 A1 10/2013 Welygan et al.  
 2013/0267150 A1 10/2013 Seider et al.  
 2013/0283705 A1 10/2013 Fischer et al.  
 2013/0305614 A1 11/2013 Gaeta et al.  
 2013/0337262 A1 12/2013 Bauer et al.  
 2013/0337725 A1 12/2013 Monroe  
 2014/0000176 A1 1/2014 Moren et al.  
 2014/0007518 A1 1/2014 Yener et al.  
 2014/0080393 A1 3/2014 Ludwig  
 2014/0106126 A1 4/2014 Gaeta et al.  
 2014/0182216 A1 7/2014 Panzarella et al.  
 2014/0182217 A1 7/2014 Yener et al.  
 2014/0186585 A1 7/2014 Field, III et al.  
 2014/0250797 A1 9/2014 Yener et al.  
 2014/0290147 A1 10/2014 Seth et al.  
 2014/0352721 A1 12/2014 Gonzales et al.  
 2014/0352722 A1 12/2014 Gonzales et al.  
 2014/0357544 A1 12/2014 Gonzales et al.  
 2014/0378036 A1 12/2014 Cichowlas et al.  
 2015/0000209 A1 1/2015 Louapre et al.  
 2015/0000210 A1 1/2015 Breder et al.  
 2015/0007399 A1 1/2015 Gonzales et al.  
 2015/0007400 A1 1/2015 Gonzales et al.  
 2015/0089881 A1 4/2015 Stevenson et al.  
 2015/0126098 A1 5/2015 Eilers et al.  
 2015/0128505 A1 5/2015 Wang et al.  
 2015/0183089 A1 7/2015 Iyengar et al.  
 2015/0218430 A1 8/2015 Yener et al.  
 2015/0232727 A1 8/2015 Erickson  
 2015/0291865 A1 10/2015 Breder et al.  
 2015/0291866 A1 10/2015 Arcona et al.

2015/0291867 A1 10/2015 Breder et al.  
 2015/0343603 A1 12/2015 Breder et al.  
 2016/0177152 A1 6/2016 Braun  
 2016/0177153 A1 6/2016 Josseaux  
 2016/0177154 A1 6/2016 Josseaux et al.  
 2016/0186028 A1 6/2016 Louapre et al.  
 2016/0214903 A1 7/2016 Humpal et al.  
 2016/0298013 A1 10/2016 Bock et al.  
 2016/0303704 A1 10/2016 Chou et al.  
 2016/0303705 A1 10/2016 Chou et al.  
 2016/0304760 A1 10/2016 Bock et al.  
 2016/0311081 A1 10/2016 Culler et al.  
 2016/0311084 A1 10/2016 Culler et al.  
 2016/0340564 A1 11/2016 Louapre et al.  
 2016/0354898 A1 12/2016 Nienaber et al.  
 2016/0362589 A1 12/2016 Bauer et al.  
 2017/0066099 A1 3/2017 Nakamura

FOREIGN PATENT DOCUMENTS

CH 685051 A5 3/1995  
 CN 102123837 B 7/2014  
 DE 102012023688 A1 4/2014  
 DE 202014101739 U1 6/2014  
 DE 202014101741 U1 6/2014  
 DE 102013202204 A1 8/2014  
 DE 102013210158 A1 12/2014  
 DE 102013210716 A1 12/2014  
 DE 102013212598 A1 12/2014  
 DE 102013212622 A1 12/2014  
 DE 102013212634 A1 12/2014  
 DE 102013212639 A1 12/2014  
 DE 102013212644 A1 12/2014  
 DE 102013212653 A1 12/2014  
 DE 102013212654 A1 12/2014  
 DE 102013212661 A1 12/2014  
 DE 102013212666 A1 12/2014  
 DE 102013212677 A1 12/2014  
 DE 102013212680 A1 12/2014  
 DE 102013212687 A1 12/2014  
 DE 102013212690 A1 12/2014  
 DE 102013212700 A1 12/2014  
 DE 102014210836 A1 12/2014  
 EP 0078896 A2 5/1983  
 EP 0152768 A3 9/1987  
 EP 0293163 A2 11/1988  
 EP 0480133 A2 4/1992  
 EP 0652919 A1 5/1995  
 EP 0662110 A1 7/1995  
 EP 0500369 B1 1/1996  
 EP 0609864 B1 11/1996  
 EP 0771769 5/1997  
 EP 0812456 B1 12/1997  
 EP 0651778 B1 5/1998  
 EP 0614861 B1 5/2001  
 EP 0931032 B1 7/2001  
 EP 0833803 8/2001  
 EP 1356152 A2 10/2003  
 EP 1371451 A1 12/2003  
 EP 1383631 B1 1/2004  
 EP 1015181 B1 3/2004  
 EP 1492845 A1 1/2005  
 EP 1851007 A1 11/2007  
 EP 1960157 A1 8/2008  
 EP 2176031 A1 4/2010  
 EP 2184134 A1 5/2010  
 EP 2390056 A2 11/2011  
 EP 1800801 B1 3/2012  
 EP 2537917 A1 12/2012  
 EP 2567784 A1 3/2013  
 EP 2631286 A1 8/2013  
 EP 2692813 A1 2/2014  
 EP 2692814 A1 2/2014  
 EP 2692815 A1 2/2014  
 EP 2692816 A1 2/2014  
 EP 2692817 A1 2/2014  
 EP 2692818 A1 2/2014  
 EP 2692819 A1 2/2014  
 EP 2692820 A1 2/2014



(56)

## References Cited

FOREIGN PATENT DOCUMENTS			WO			
EP	2692821	A1	2/2014	WO	2012/141905	A2 10/2012
EP	2719752	A1	4/2014	WO	2013/003830	A2 1/2013
EP	2720676	A1	4/2014	WO	2013/003831	A2 1/2013
EP	2012972	B1	6/2014	WO	2013/009484	A2 1/2013
FR	2354373	A1	1/1978	WO	2013/036402	A1 3/2013
GB	986847	A	3/1965	WO	2013/045251	A1 4/2013
JP	53064890	A	6/1978	WO	2013/049239	A1 4/2013
JP	60-006356	U	1/1985	WO	2013070576	A2 5/2013
JP	62002946	B	1/1987	WO	2013/102170	A1 7/2013
JP	63036905	B	7/1988	WO	2013/102176	A1 7/2013
JP	3079277	A	4/1991	WO	2013/102177	A1 7/2013
JP	03-287687		12/1991	WO	2013/106597	A1 7/2013
JP	5285833	A	11/1993	WO	2013/106602	A1 7/2013
JP	6114739	A	4/1994	WO	2013/151745	A1 10/2013
JP	7008474	B2	2/1995	WO	2013/177446	A1 11/2013
JP	10113875	A	5/1998	WO	2013/188038	A1 12/2013
JP	2779252	B2	7/1998	WO	2014/005120	A1 1/2014
JP	10330734	A	12/1998	WO	2014/161001	A1 2/2014
JP	H10315142	A	12/1998	WO	2014020068	A1 2/2014
JP	2957492	B2	10/1999	WO	2014020075	A1 2/2014
JP	2000091280	A	3/2000	WO	2014022453	A1 2/2014
JP	2000-336344	A	12/2000	WO	2014022462	A1 2/2014
JP	3160084	B2	4/2001	WO	2014022465	A1 2/2014
JP	2001162541	A	6/2001	WO	2014/057273	A1 4/2014
JP	03194269	B2	7/2001	WO	2014/062701	A1 4/2014
JP	2001207160	A	7/2001	WO	2014/070468	A1 5/2014
JP	2001516652	A	10/2001	WO	2014/106173	A1 7/2014
JP	2002-038131	A	2/2002	WO	2014/106211	A1 7/2014
JP	2003-049158	A	2/2003	WO	2014/124554	A1 8/2014
JP	2004-510873	A	4/2004	WO	2014/137972	A1 9/2014
JP	2004209624	A	7/2004	WO	2014/140689	A1 9/2014
JP	2006159402	A	6/2006	WO	2014/165390	A1 10/2014
JP	2006-192540	A	7/2006	WO	2014/176108	A1 10/2014
JP	2008194761	A	8/2008	WO	2014/206739	A1 12/2014
JP	2011507718	A	3/2011	WO	2014/206890	A1 12/2014
JP	5238725	B2	7/2013	WO	2014/206967	A1 12/2014
JP	5238726	B2	7/2013	WO	2014/209567	A1 12/2014
JP	2014503367	A	2/2014	WO	2014/210160	A1 12/2014
KR	20080037693	A	4/2008	WO	2014/210442	A1 12/2014
KR	20110100278	A	9/2011	WO	2014/210532	A1 12/2014
NL	171464	B	11/1982	WO	2014/210568	A1 12/2014
WO	9402559	A1	2/1994	WO	2015/050781	A1 4/2015
WO	95/03370		2/1995	WO	2015/073346	A1 5/2015
WO	95/18192	A1	7/1995	WO	2015/088953	A1 6/2015
WO	9520469	A1	8/1995	WO	2015/089527	A1 6/2015
WO	96/27189	A1	9/1996	WO	2015/089528	A1 6/2015
WO	9714536	A1	4/1997	WO	2015/089529	A1 6/2015
WO	9906500	A1	2/1999	WO	2015/100018	A1 7/2015
WO	99/38817	A1	8/1999	WO	2015/100020	A1 7/2015
WO	9938817	A1	8/1999	WO	2015/100220	A1 7/2015
WO	9954424	A1	10/1999	WO	2015/112379	A1 7/2015
WO	01/14494	A1	3/2001	WO	2015/130487	A1 9/2015
WO	02097150		12/2002	WO	2015/158009	A1 10/2015
WO	03/087236	A1	10/2003	WO	2015/164211	A1 10/2015
WO	2005/080624	A1	9/2005	WO	2015/165122	A1 11/2015
WO	2006/027593		3/2006	WO	2015/167910	A1 11/2015
WO	2007/041538	A1	4/2007	WO	2015/179335	A1 11/2015
WO	2009085578	A2	7/2009	WO	2015/180005	A1 12/2015
WO	2010/077509	A1	7/2010	WO	2016/028683	A1 2/2016
WO	2010085587	A1	7/2010	WO	2016/044158	A1 3/2016
WO	2010/151201		12/2010	WO	2016/064726	A1 4/2016
WO	2011/068724	A2	6/2011	WO	2016/089675	A1 6/2016
WO	2011068714	A2	6/2011	WO	2016/160357	A 10/2016
WO	2011087649	A2	7/2011	WO	2016/161157	A1 10/2016
WO	2011/109188	A2	9/2011	WO	2016/161170	A1 10/2016
WO	2011109188	A2	9/2011	WO	2016/167967	A1 10/2016
WO	2011/139562	A2	11/2011	WO	2016/196795	A1 12/2016
WO	2011/149625	A2	12/2011	WO	2016/205133	A1 12/2016
WO	2012/018903	A2	2/2012	WO	2016/205267	A1 12/2016
WO	2012/061016	A1	5/2012	WO	2016/210057	A1 12/2016
WO	2012/061033	A2	5/2012	WO	2017/007703	A1 1/2017
WO	2012/092590	A2	7/2012	WO	2017/007714	A1 1/2017
WO	2012/092605	A2	7/2012	WO	2017/062482	A1 4/2017
WO	2012/112305	A2	8/2012			
WO	2012/112322	A2	8/2012			

## OTHER PUBLICATIONS

"Investigation of Shaped Abrasive Particles vol. 1: Review of U.S. Pat. No. 6,054,093 Apr. 25, 2000" © Apr. 2011, 5 pages.

(56)

**References Cited**

## OTHER PUBLICATIONS

Austin, Benson M., "Thick-Film Screen Printing," *Solid State Technology*, Jun. 1969, pp. 53-58.

Avril, Nicholas Joseph, "Manufacturing Glass-fiber Reinforcement for Grinding Wheels," Massachusetts Institute of Technology, 1996, 105 pgs.

Bacher, Rudolph J., "High Resolution Thick Film Printing," E.I. du Pont de Nemours & Company, Inc., pp. 576-581, date unknown.

Besse, John R., "Understanding and controlling wheel truing and dressing forces when rotary plunge dressing," *Cutting Tool Engineering*, Jun. 2012, vol. 64, Issue 6, 5 pages.

Brewer, L. et al., *Journal of Materials Research*, 1999, vol. 14, No. 10, pp. 3907-3912.

Ciccotti, M. et al., "Complex dynamics in the peeling of an adhesive tape," *International Journal of Adhesion & Adhesives* 24 (2004) pp. 143-151.

Dupont, "Kevlar Aramid Pulp", Copyright 2011, DuPont, 1 page.

Wu, J. et al., Friction and Wear Properties of Kevlar Pulp Reinforced Epoxy.

J. European Ceramic Society 31, Abstract only (2011) 2073-2081.

Riemer, Dietrich E., "Analytical Engineering Model of the Screen Printing Process: Part II," *Solid State Technology*, Sep. 1988, pp. 85-90.

Miller, L.F., "Paste Transfer in the Screening Process," *Solid State Technology*, Jun. 1969, pp. 46-52.

Morgan, P. et al., "Ceramic Composites of Monazite and Alumina," *J. Am. Ceram. Soc.*, 78, 1995, 1553-63.

Riemer, Dietrich E., "Analytical Engineering Model of the Screen Printing Process: Part I," *Solid State Technology*, Aug. 1988, pp. 107-111.

Winter Catalogue No. 5, Dressing tools, Winter diamond tools for dressing grinding wheels, 140 pages.

Badger, Jeffrey, "Evaluation of Triangular, Engineered-Shape Ceramic Abrasive in Cutting Discs," *Supplement to the Welding Journal*, Apr. 2014, vol. 93, pp. 107-s to 115-s.

3M Cubitron II Abrasive Belts Brochure, *Shaping the Future*, Jan. 2011, 6 pages.

Vanstrum et al., *Precisely Shaped Grain (PSG): 3M's Innovation in Abrasive Grain Technology*, date unknown, 1 page.

Graf, "Cubitron II: Precision-Shaped Grain (PSG) Turns the Concept of Gear Grinding Upside Down," *gearsolutions.com*, May 2014, pp. 36-44.

Supplementary Partial European Search Report for EP12861869, mailed on Mar. 15, 2016, 9 pages.

\* cited by examiner

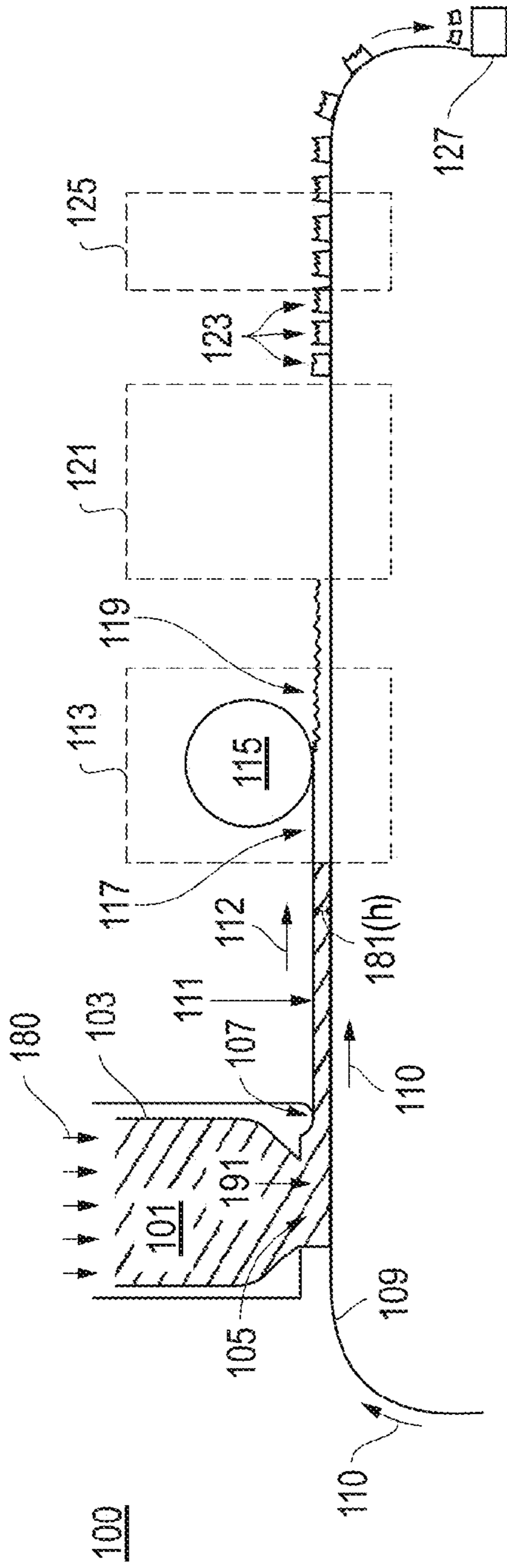


FIG. 1A

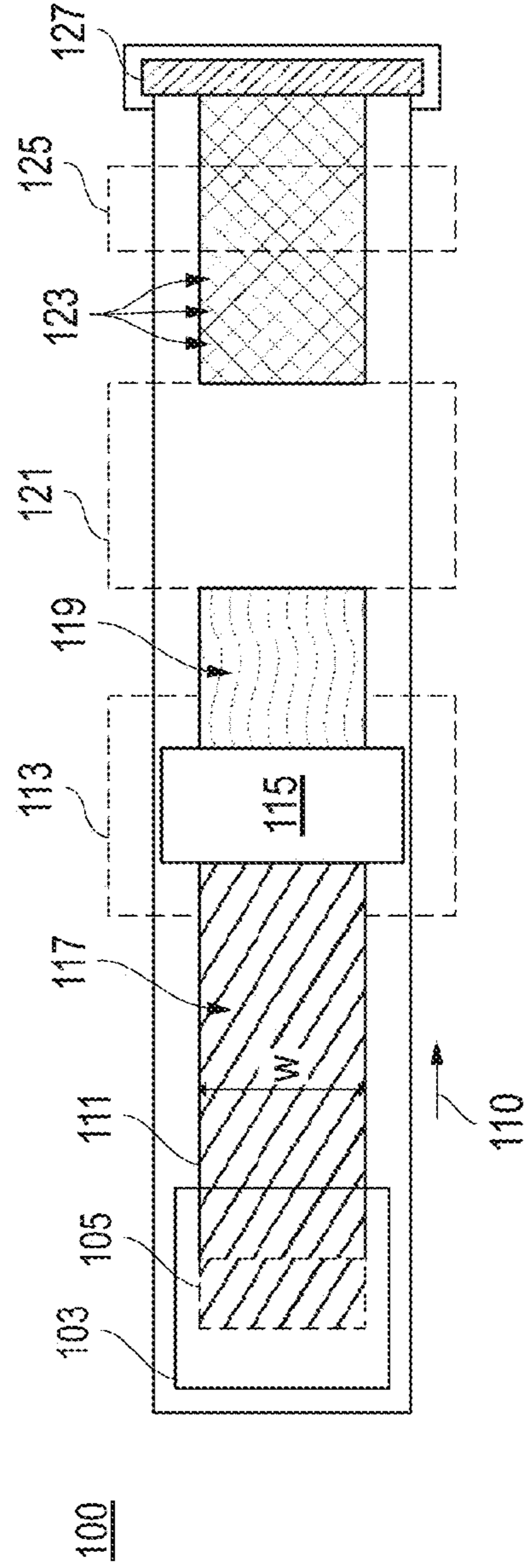


FIG. 1B



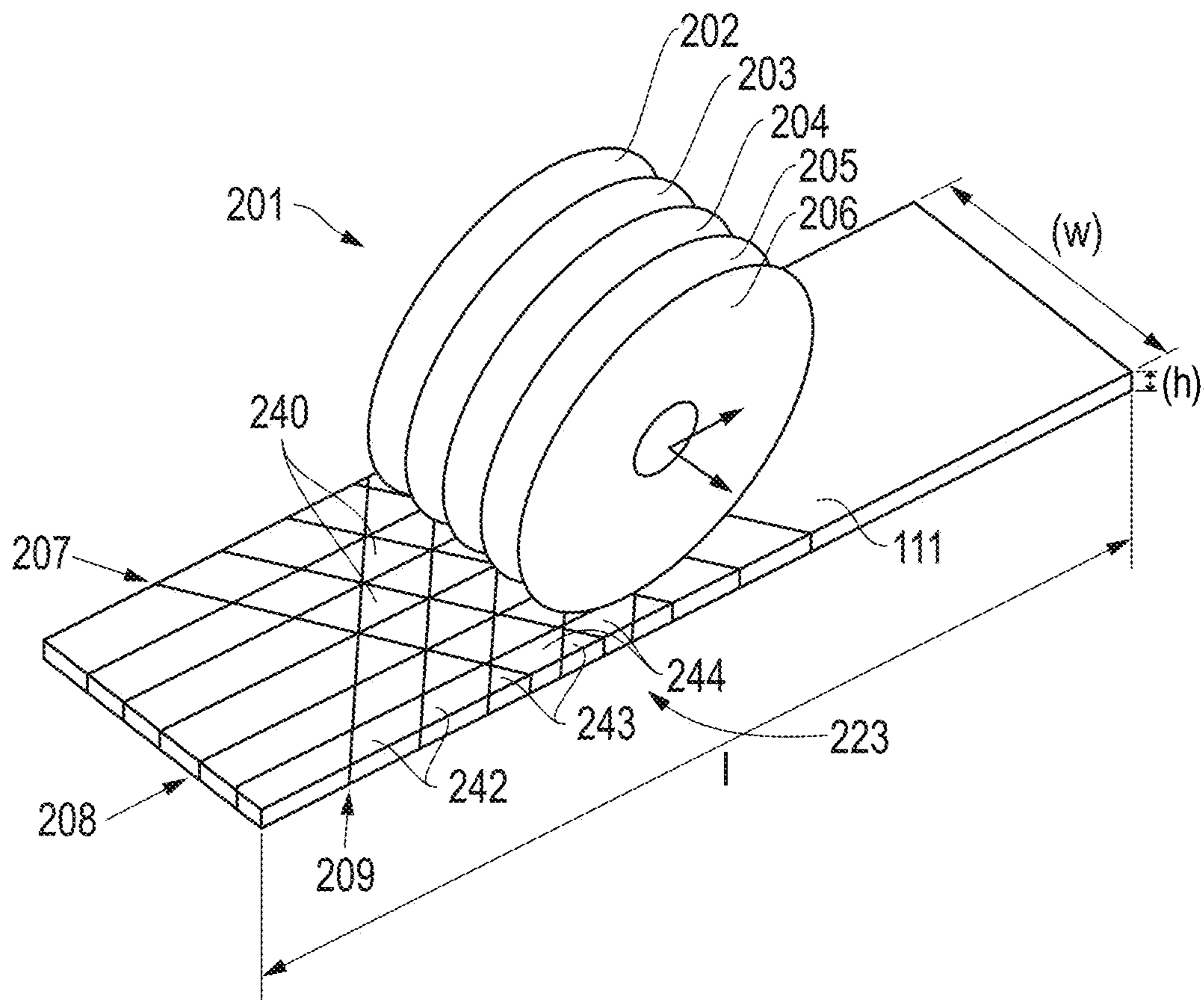


FIG. 2

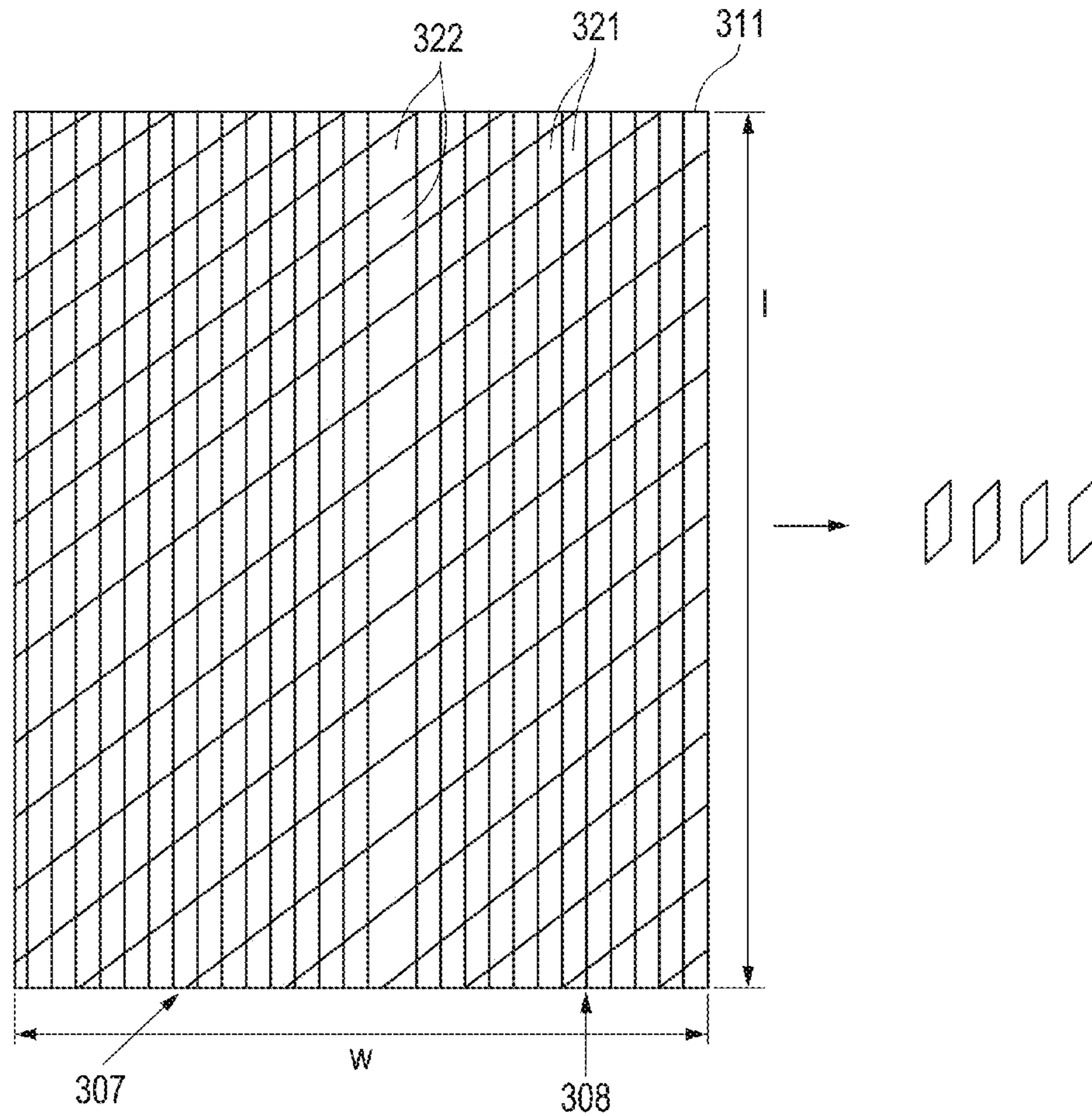


FIG. 3

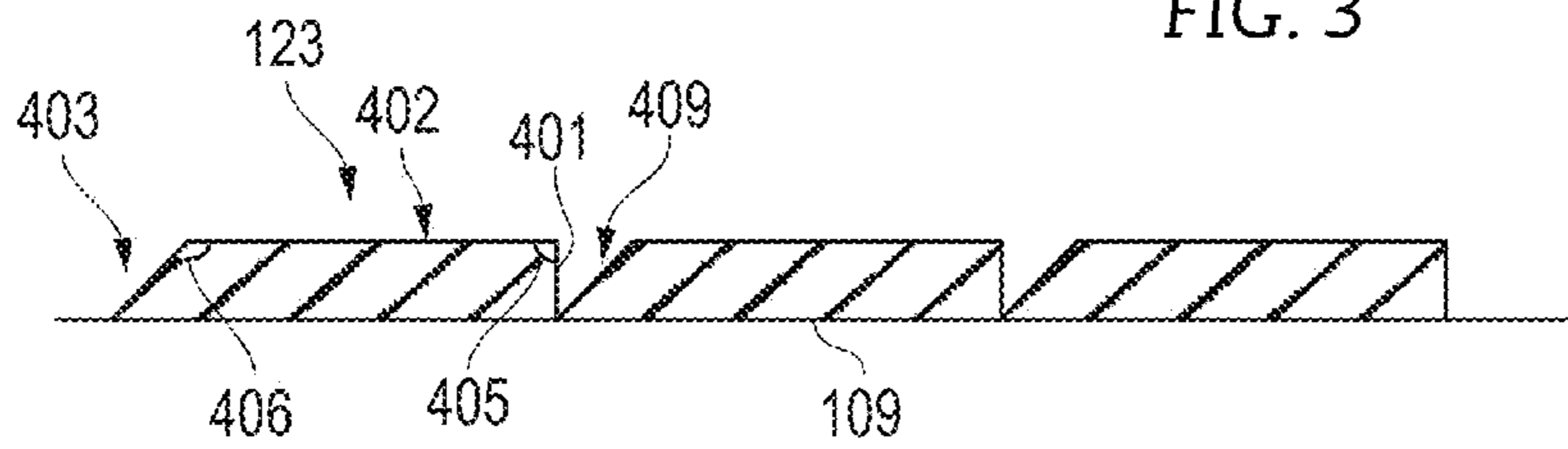


FIG. 4A

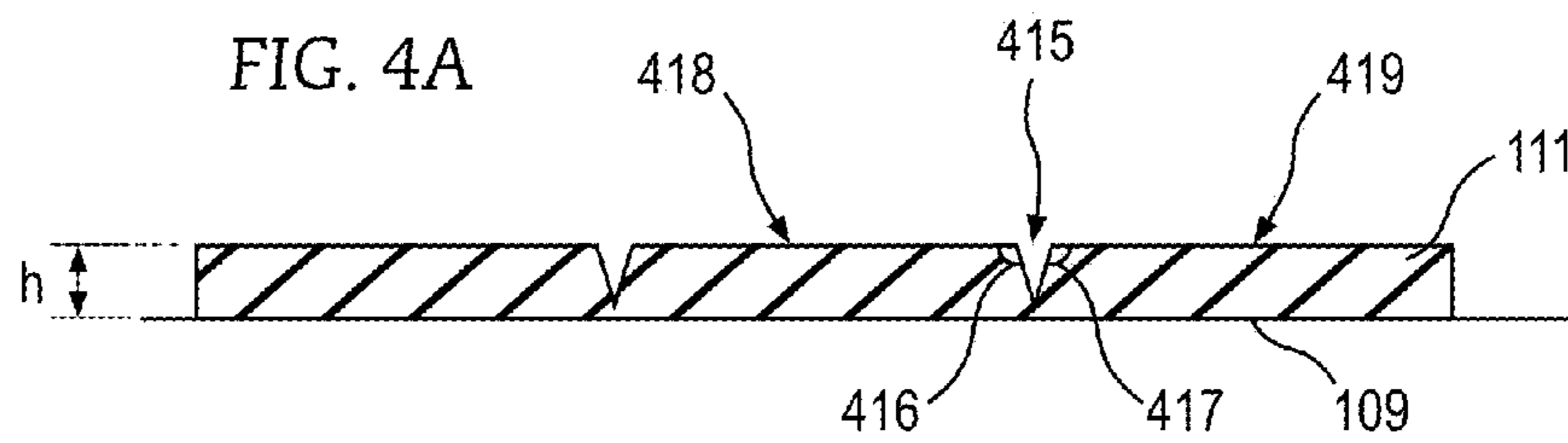


FIG. 4B



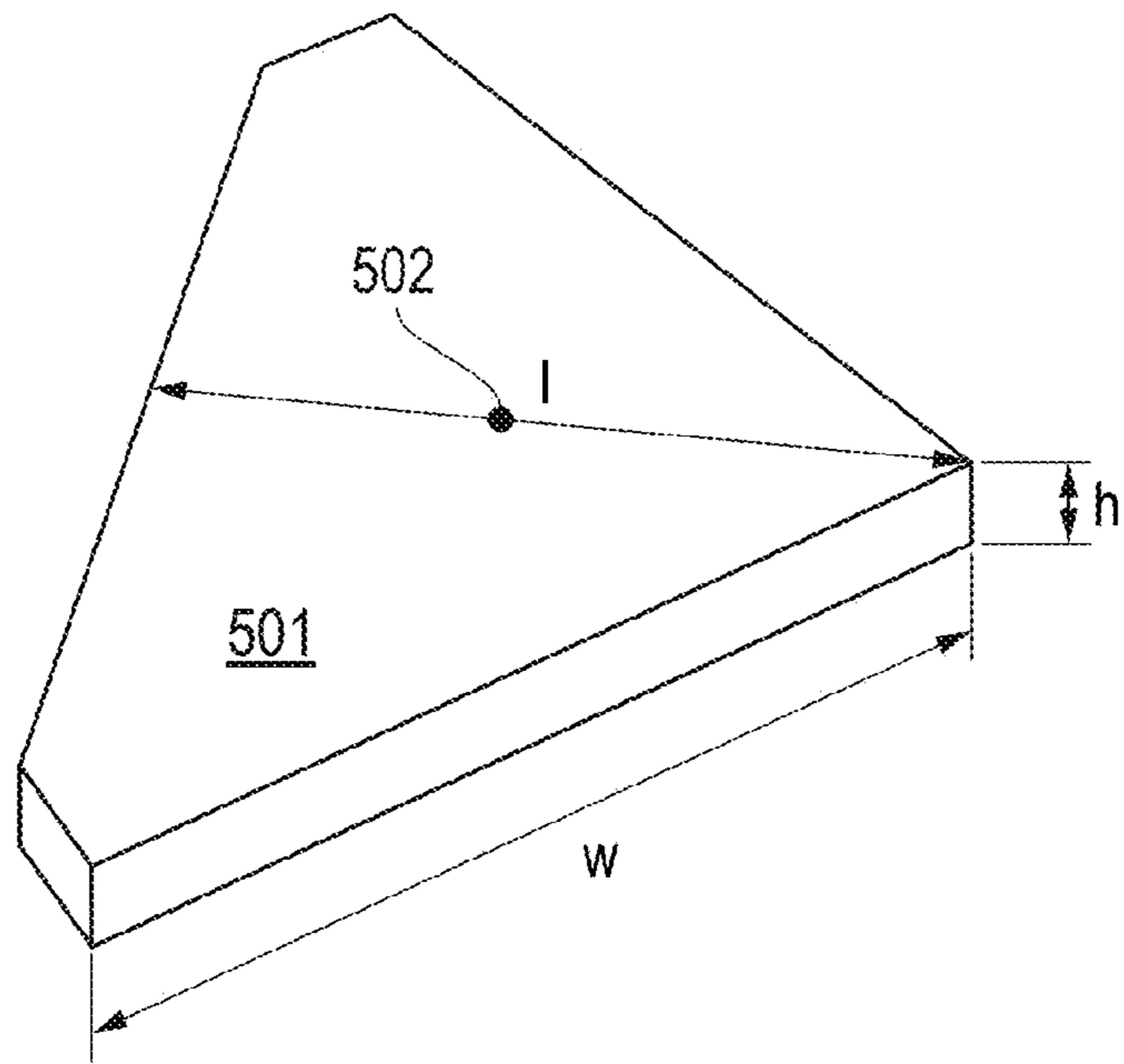


FIG. 5

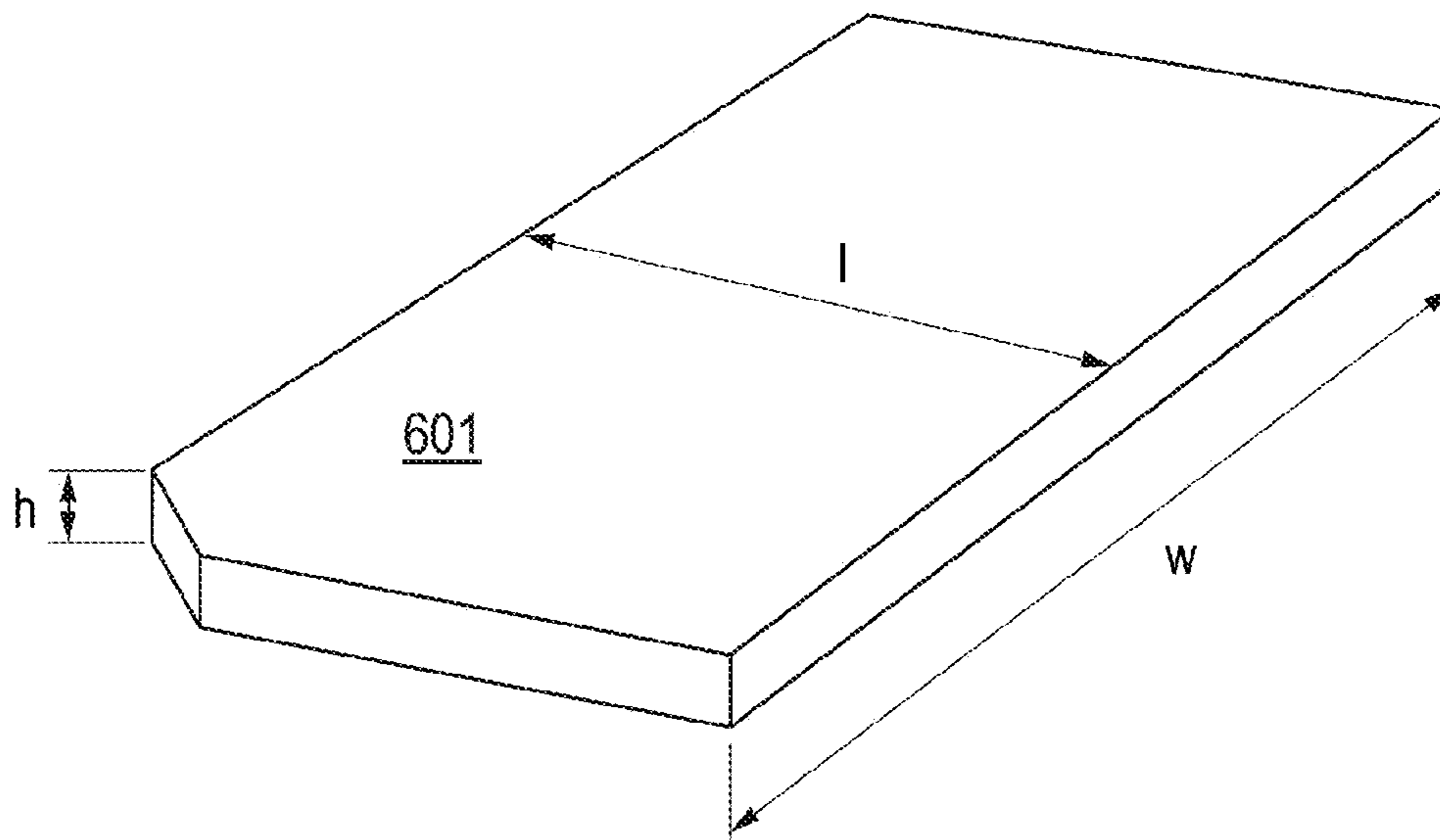


FIG. 6

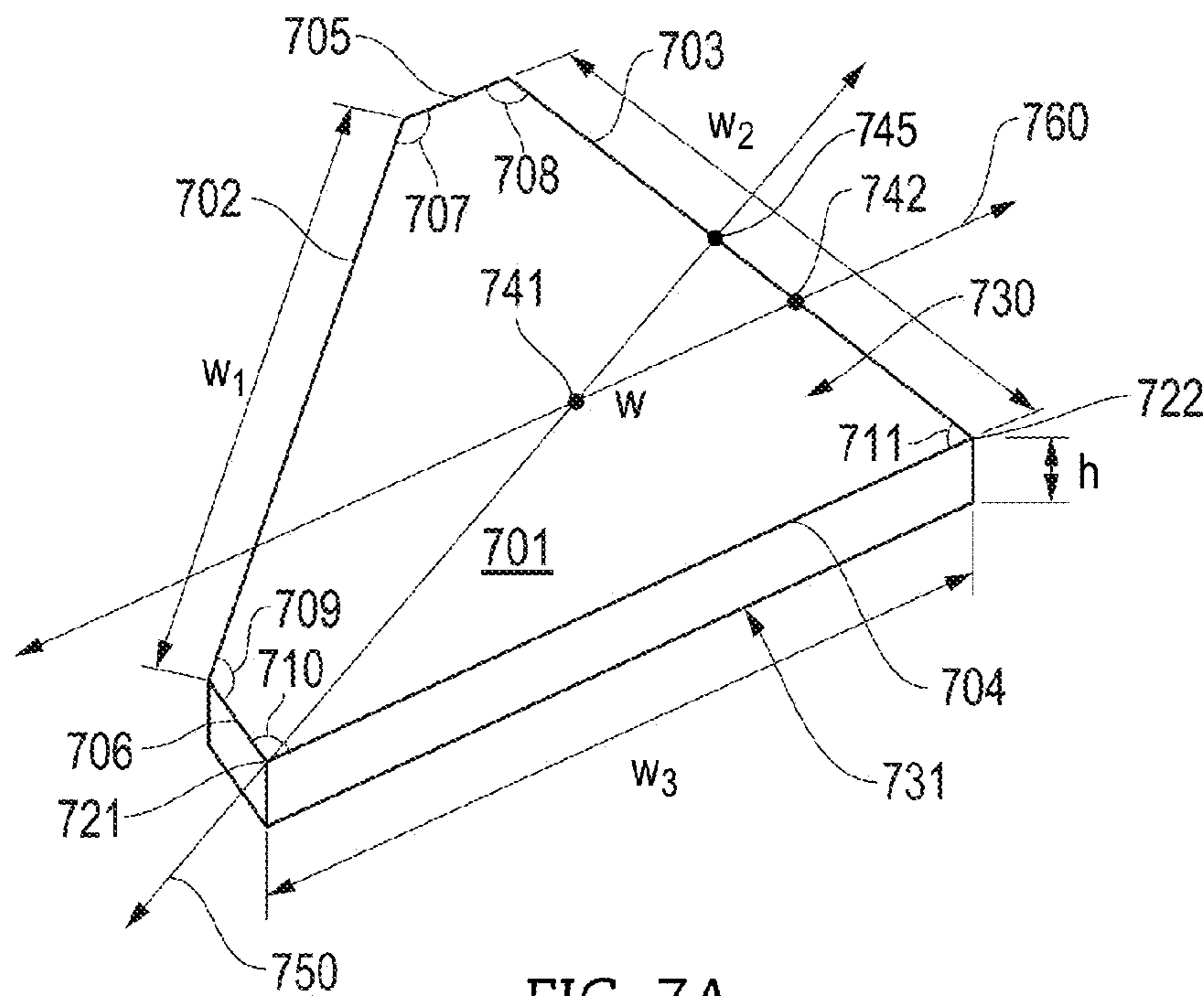


FIG. 7A

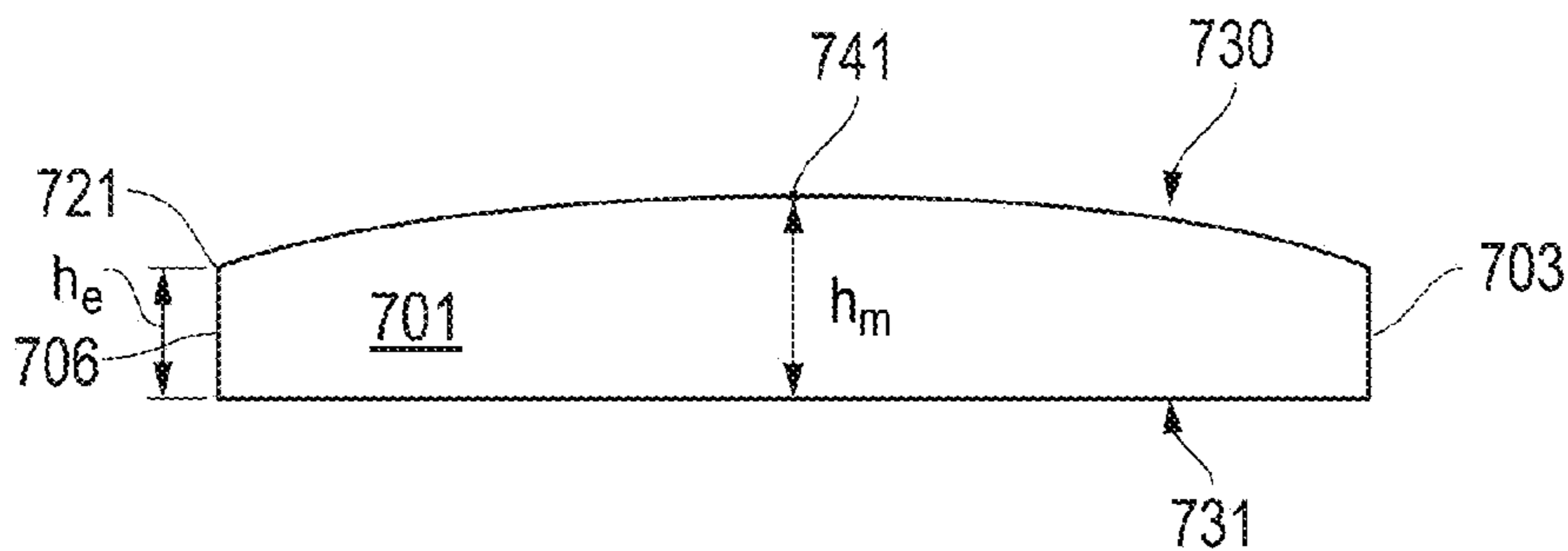


FIG. 7B

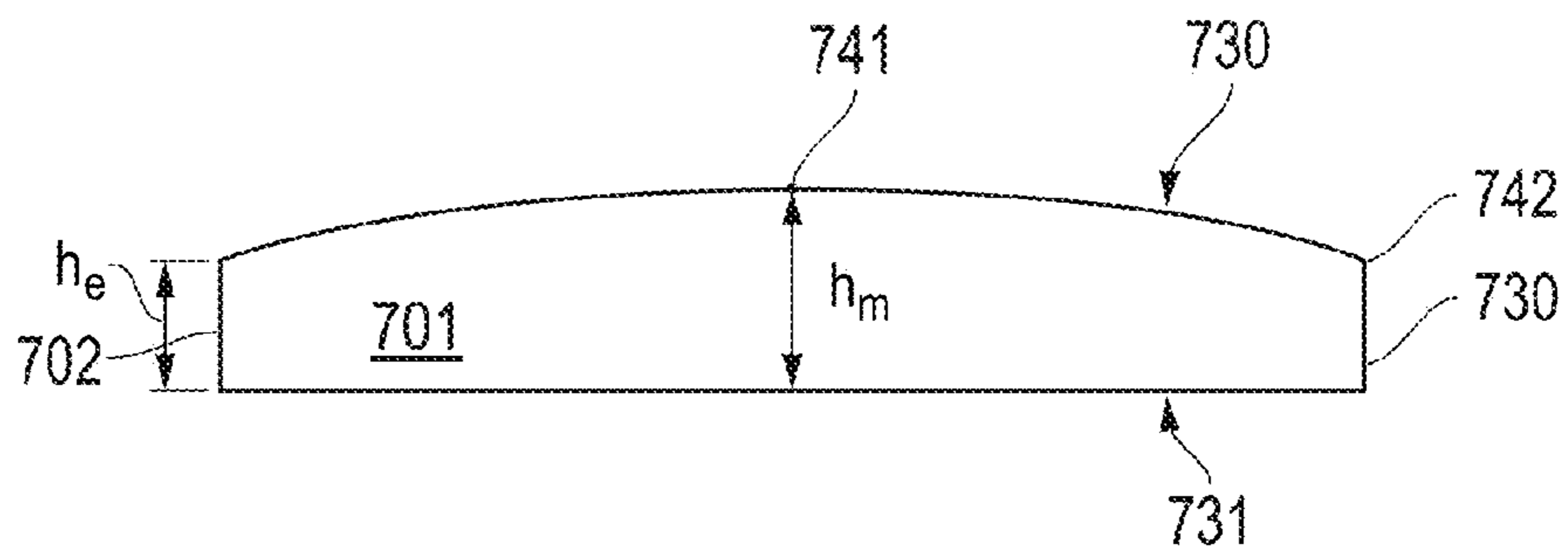


FIG. 7C



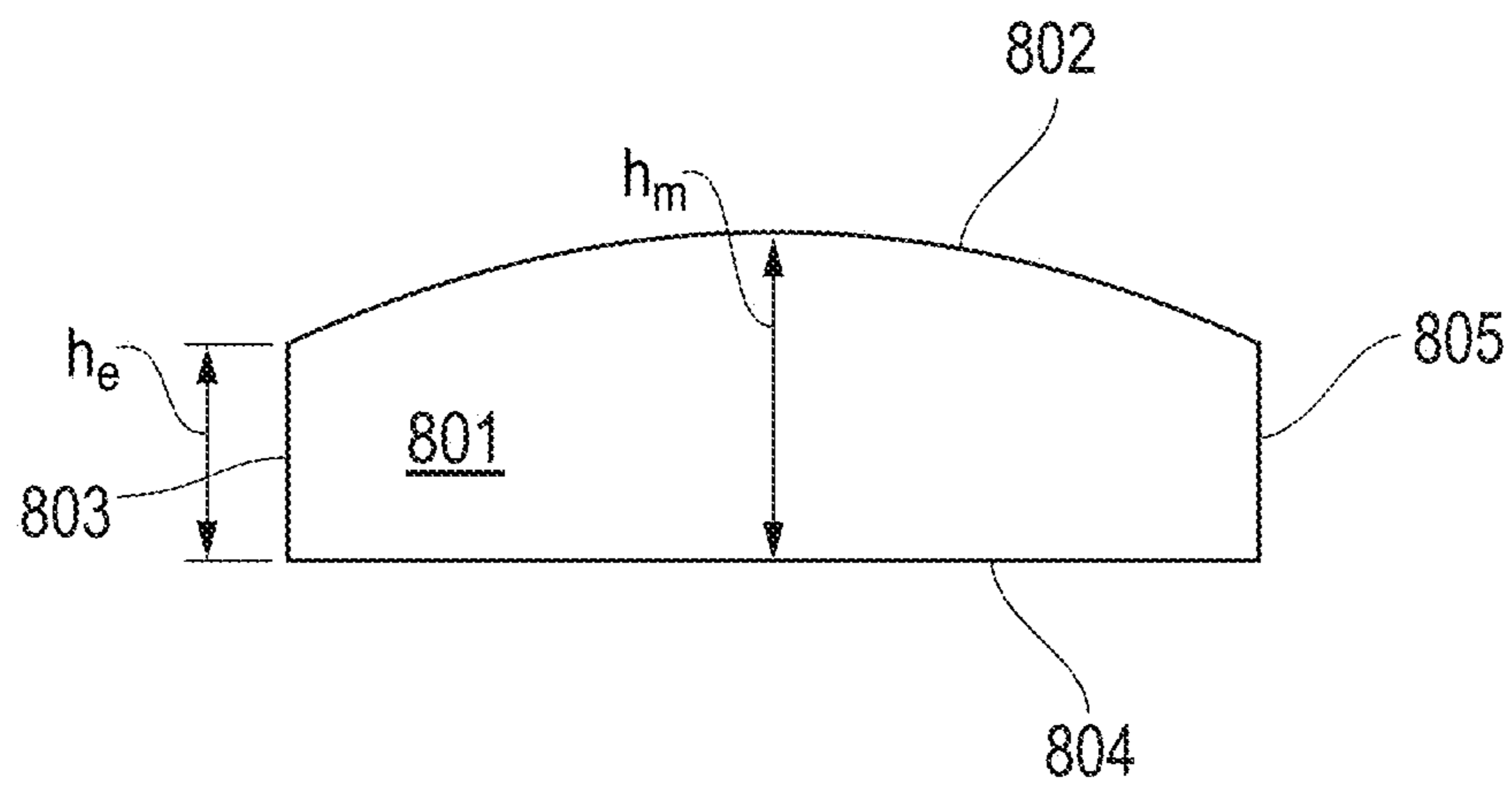


FIG. 8

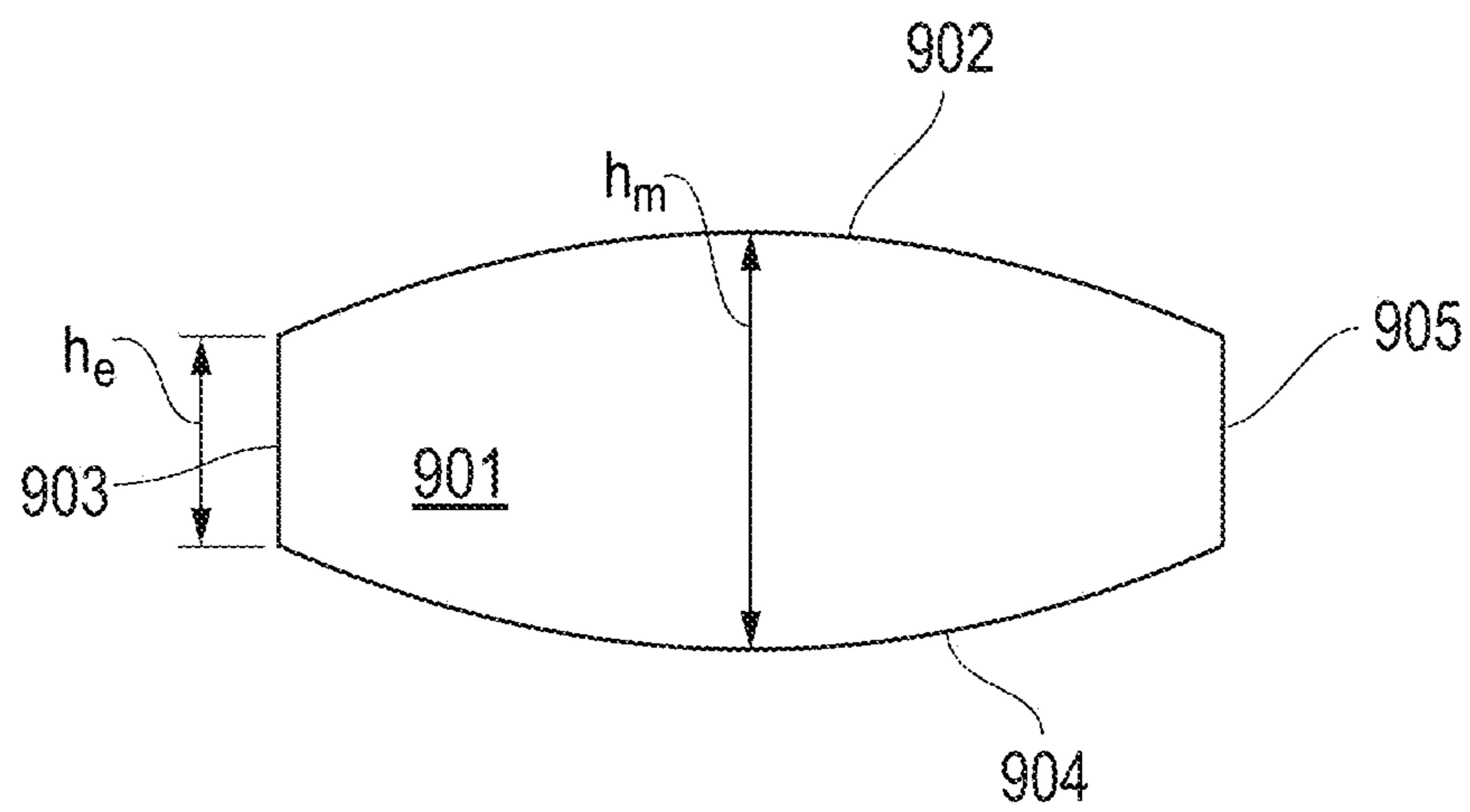


FIG. 9





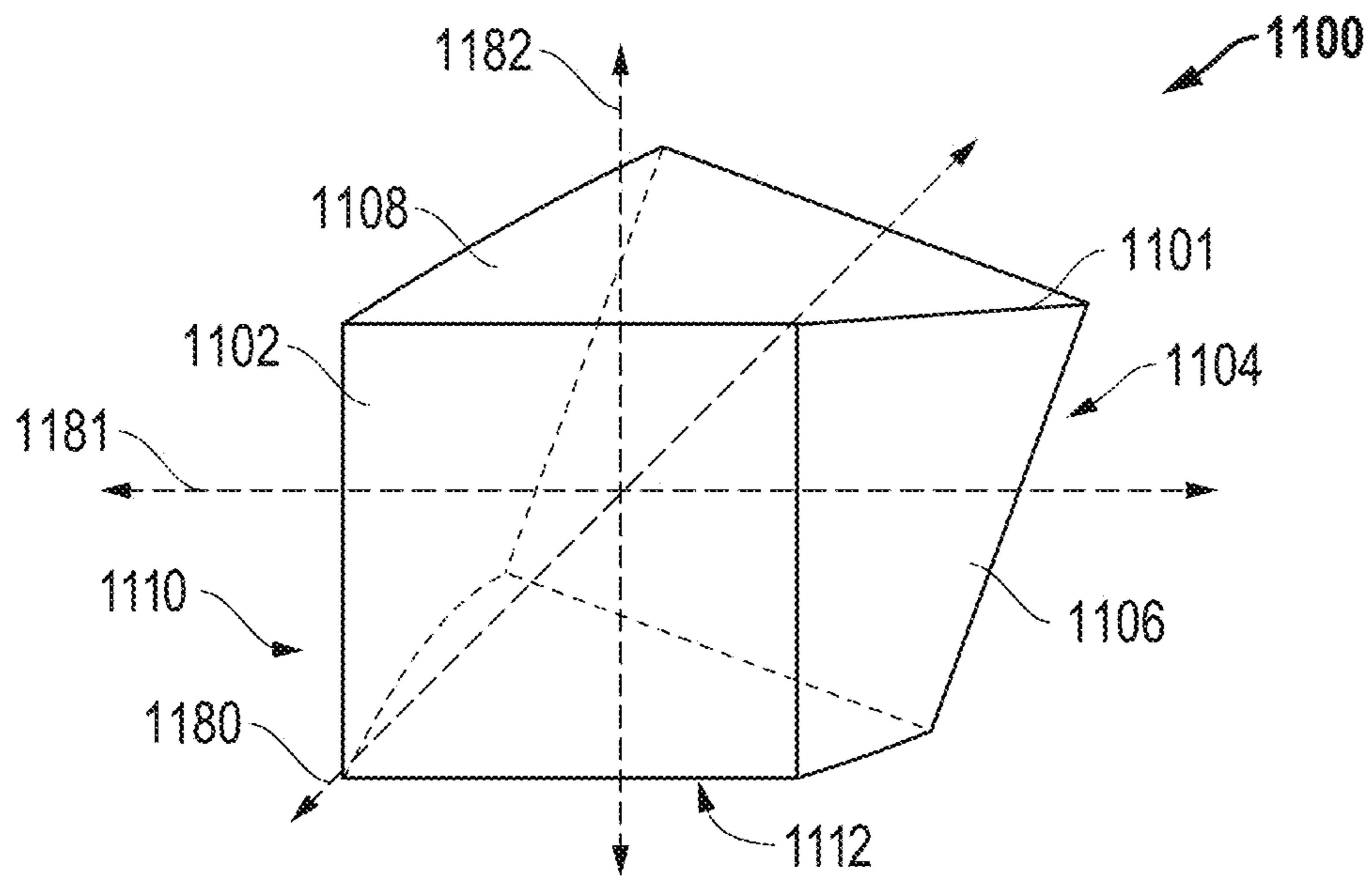


FIG. 11

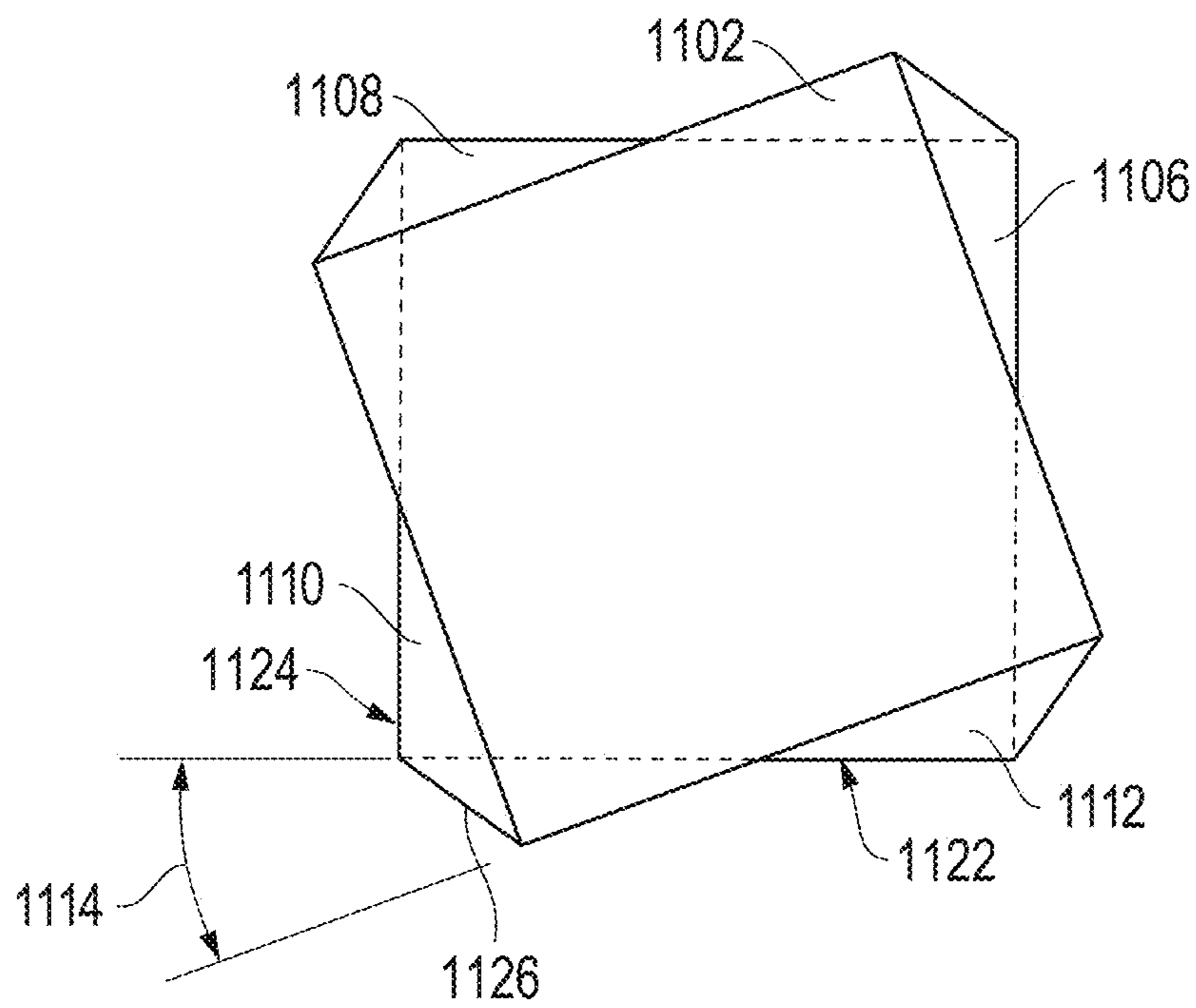


FIG. 12

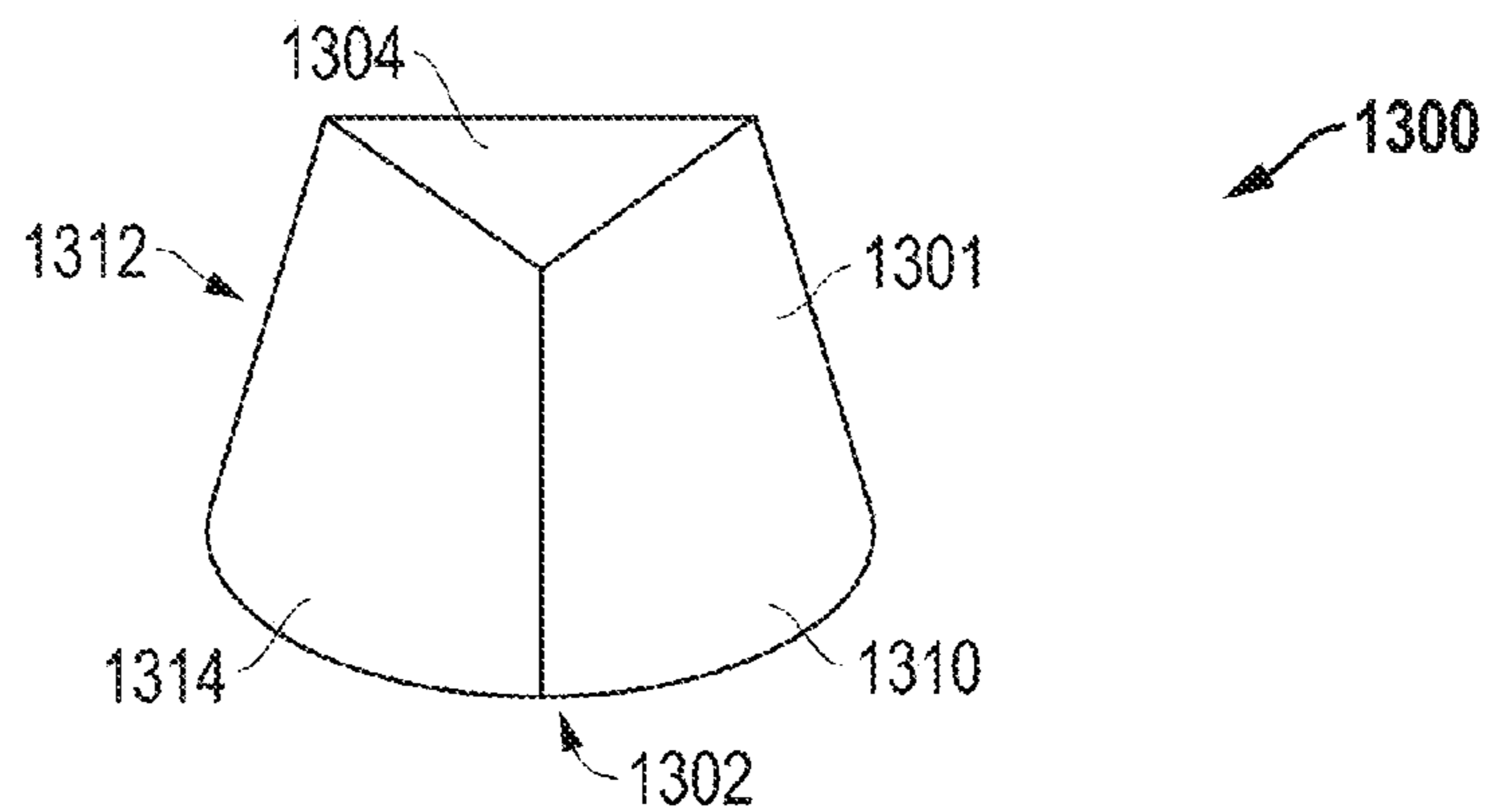


FIG. 13

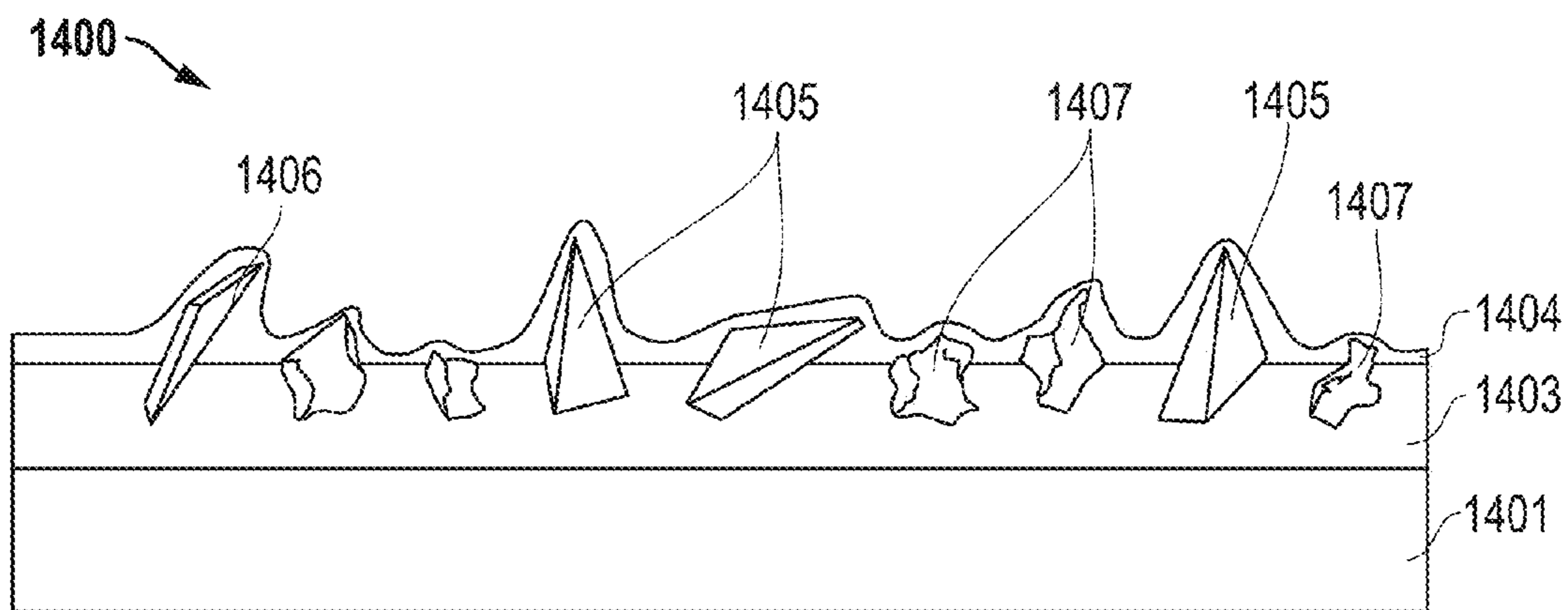


FIG. 14

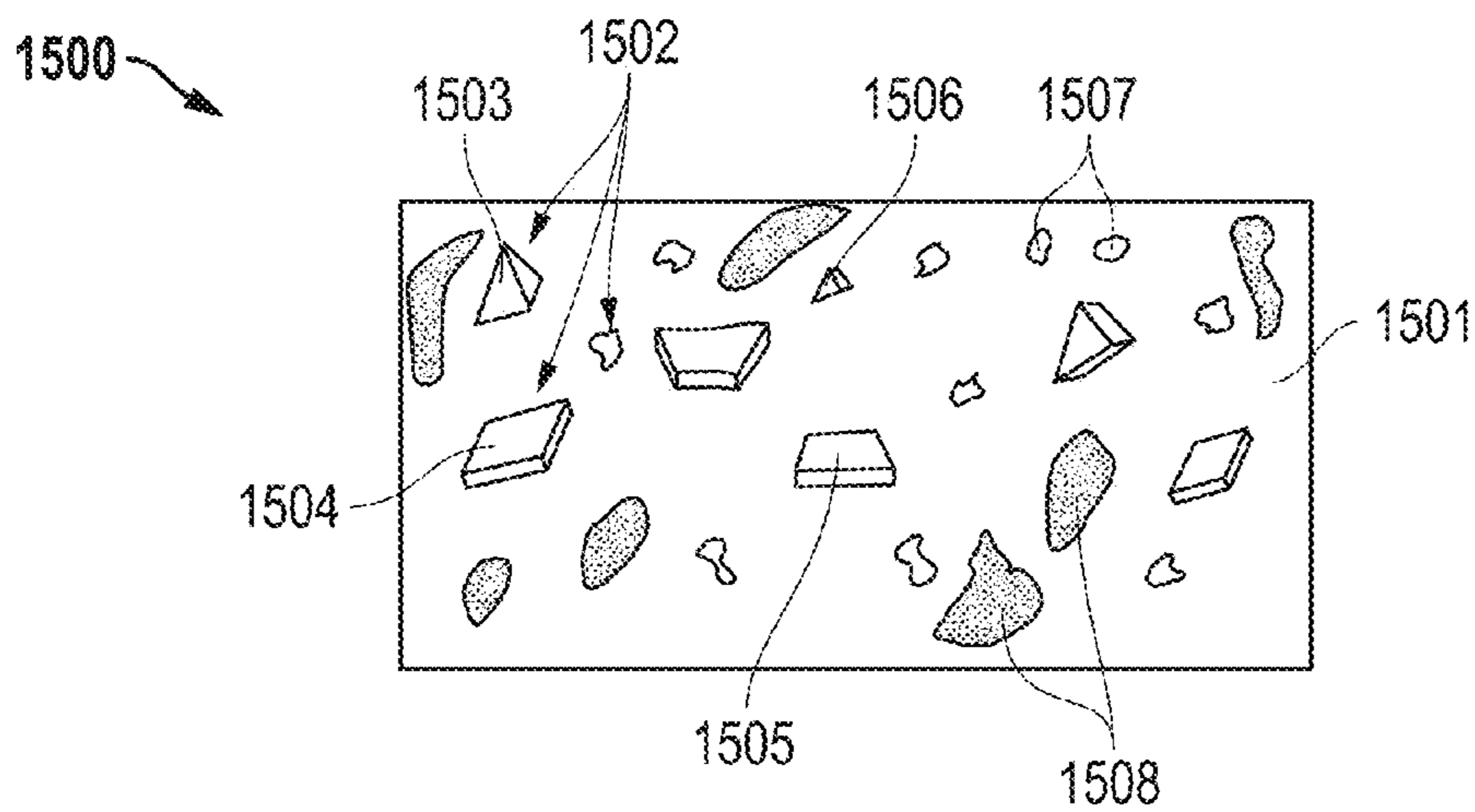


FIG. 15

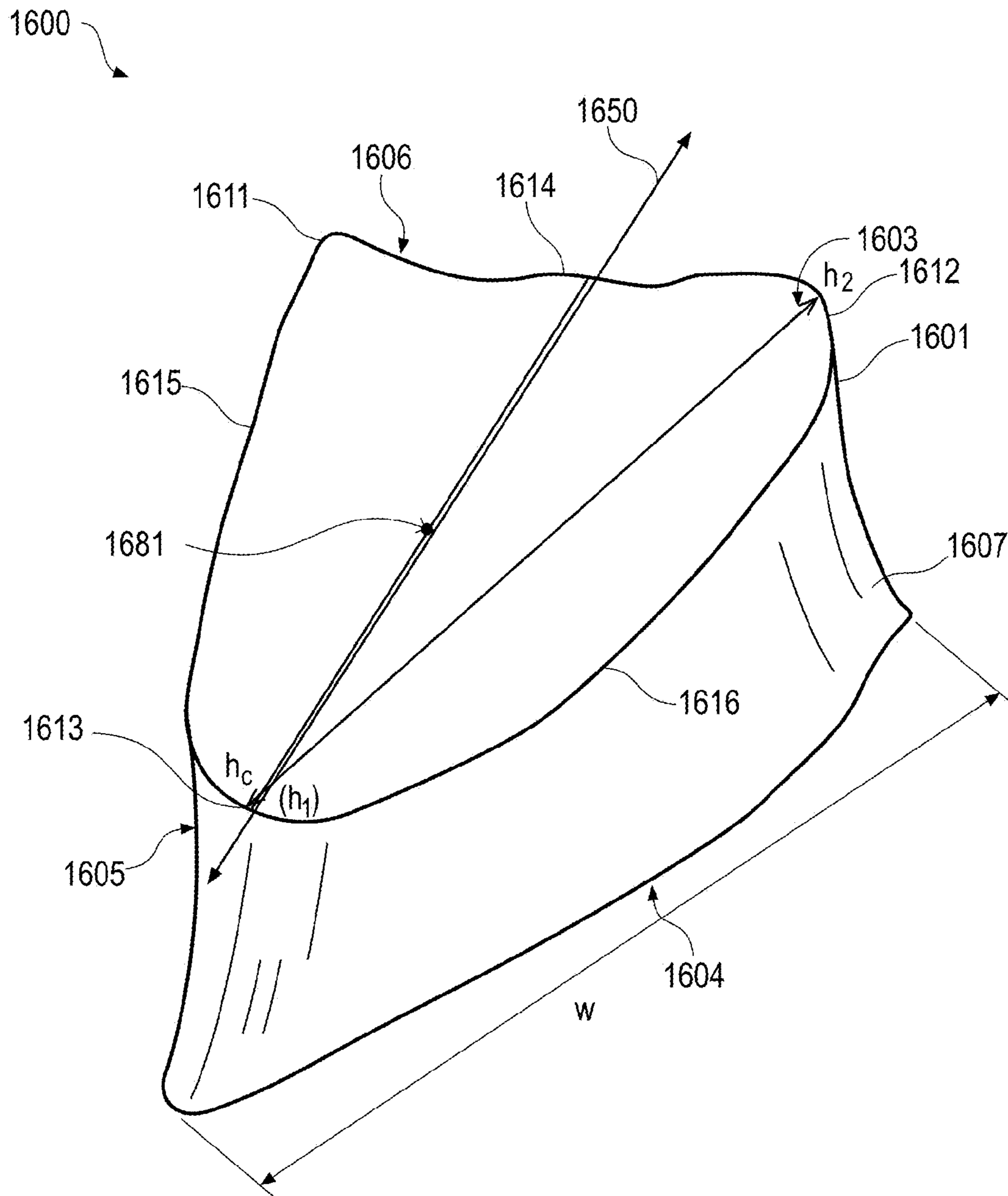


FIG. 16A



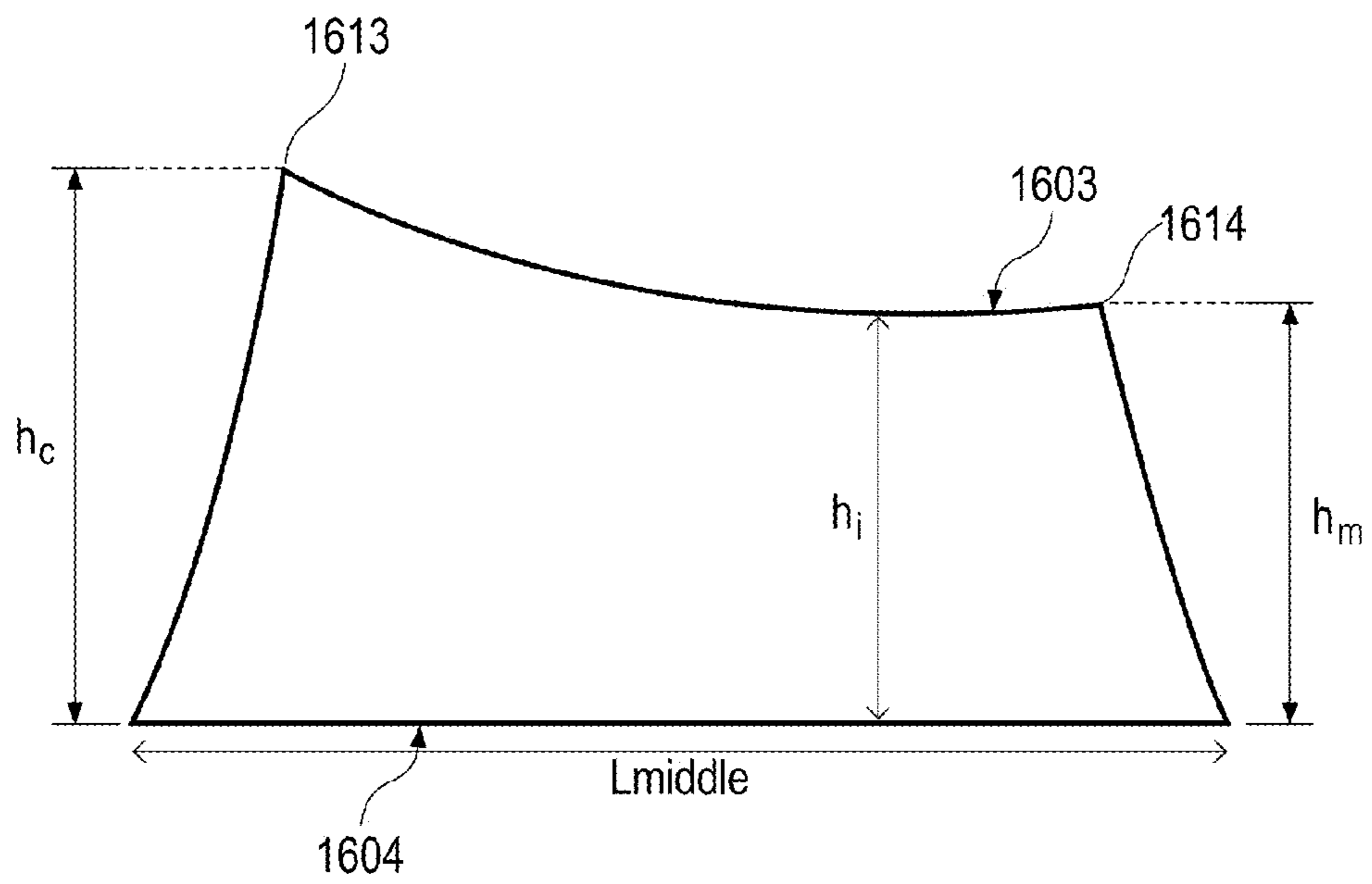


FIG. 16B

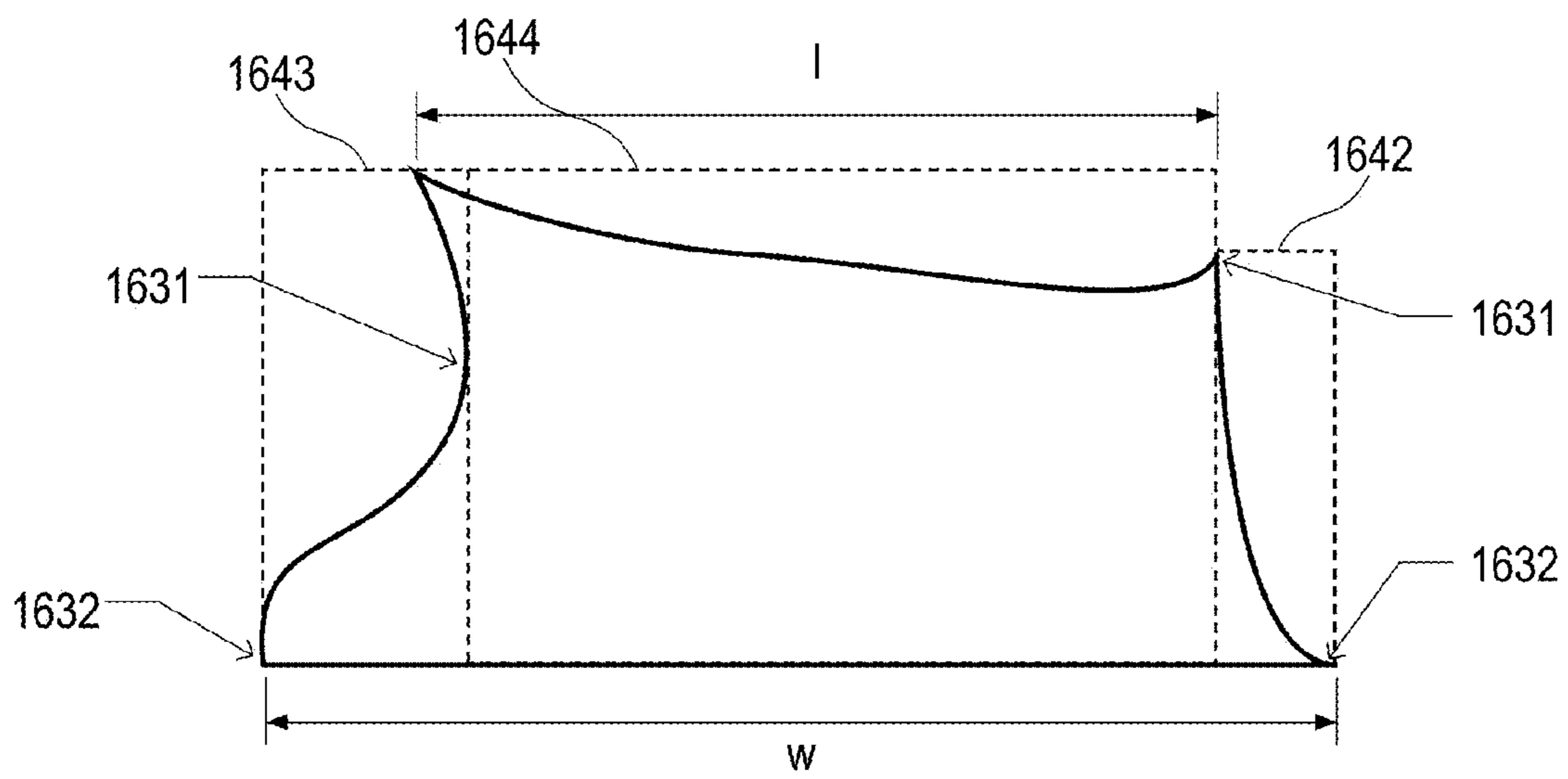


FIG. 16C

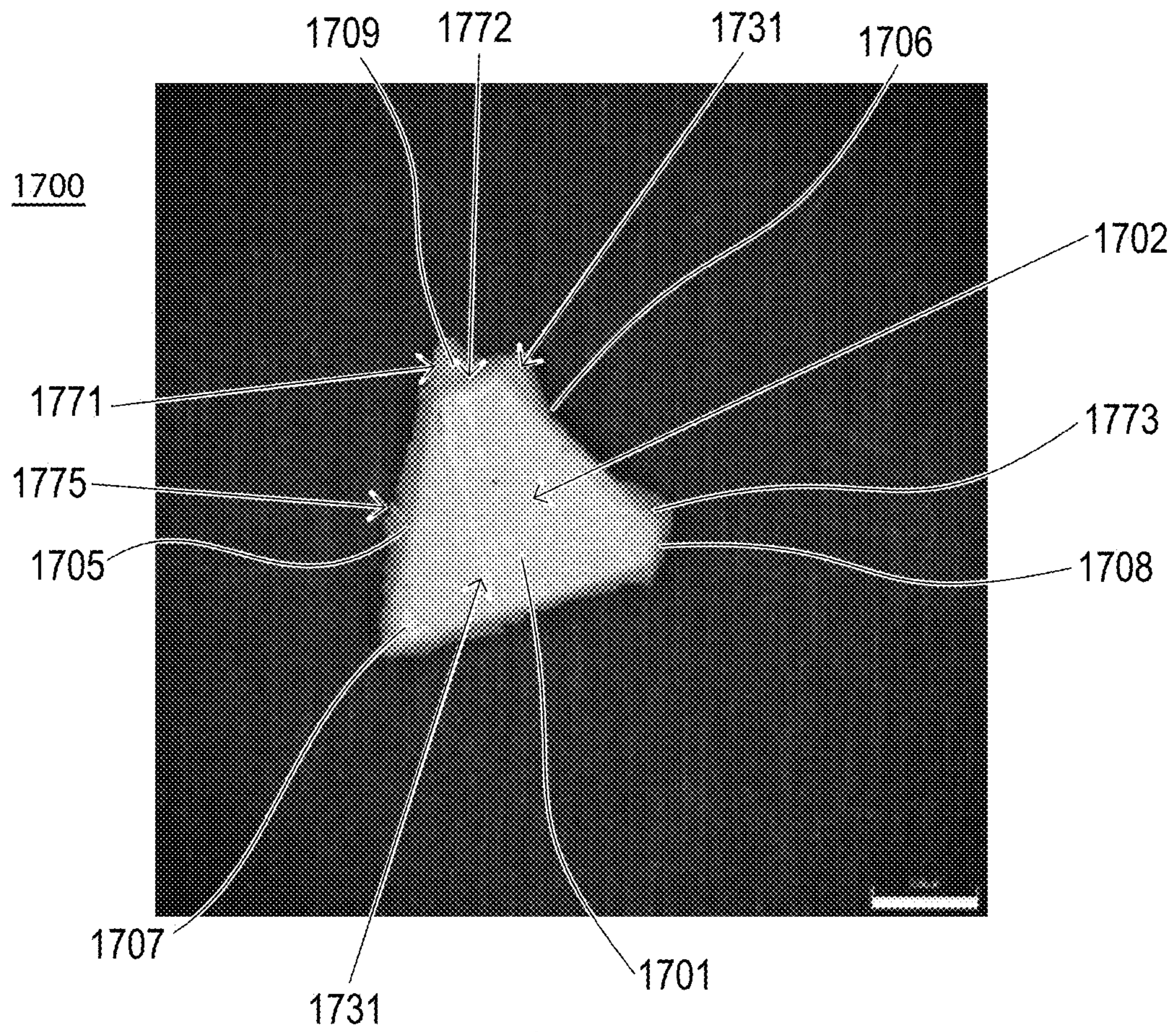


FIG. 17A



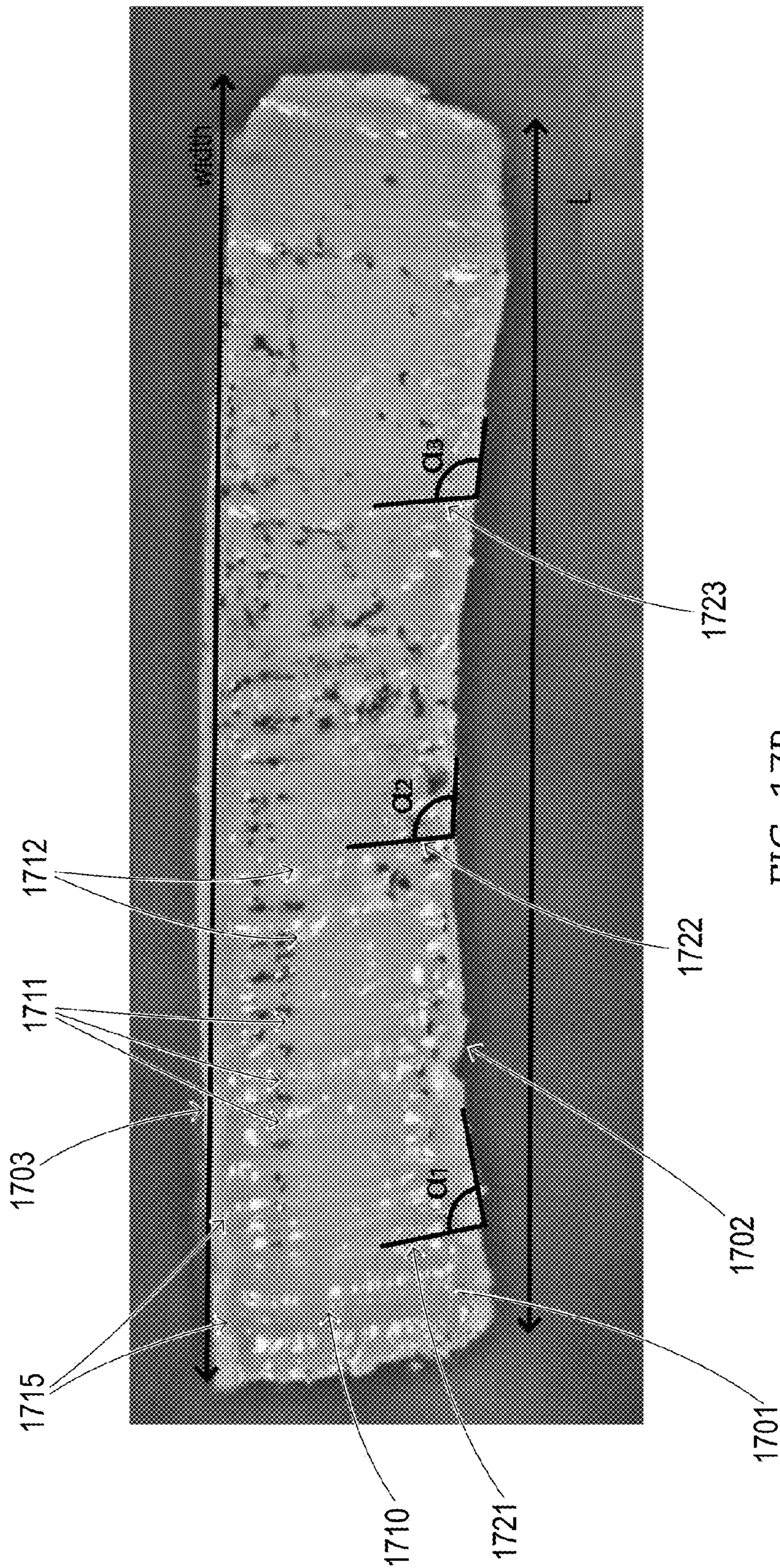


FIG. 17B



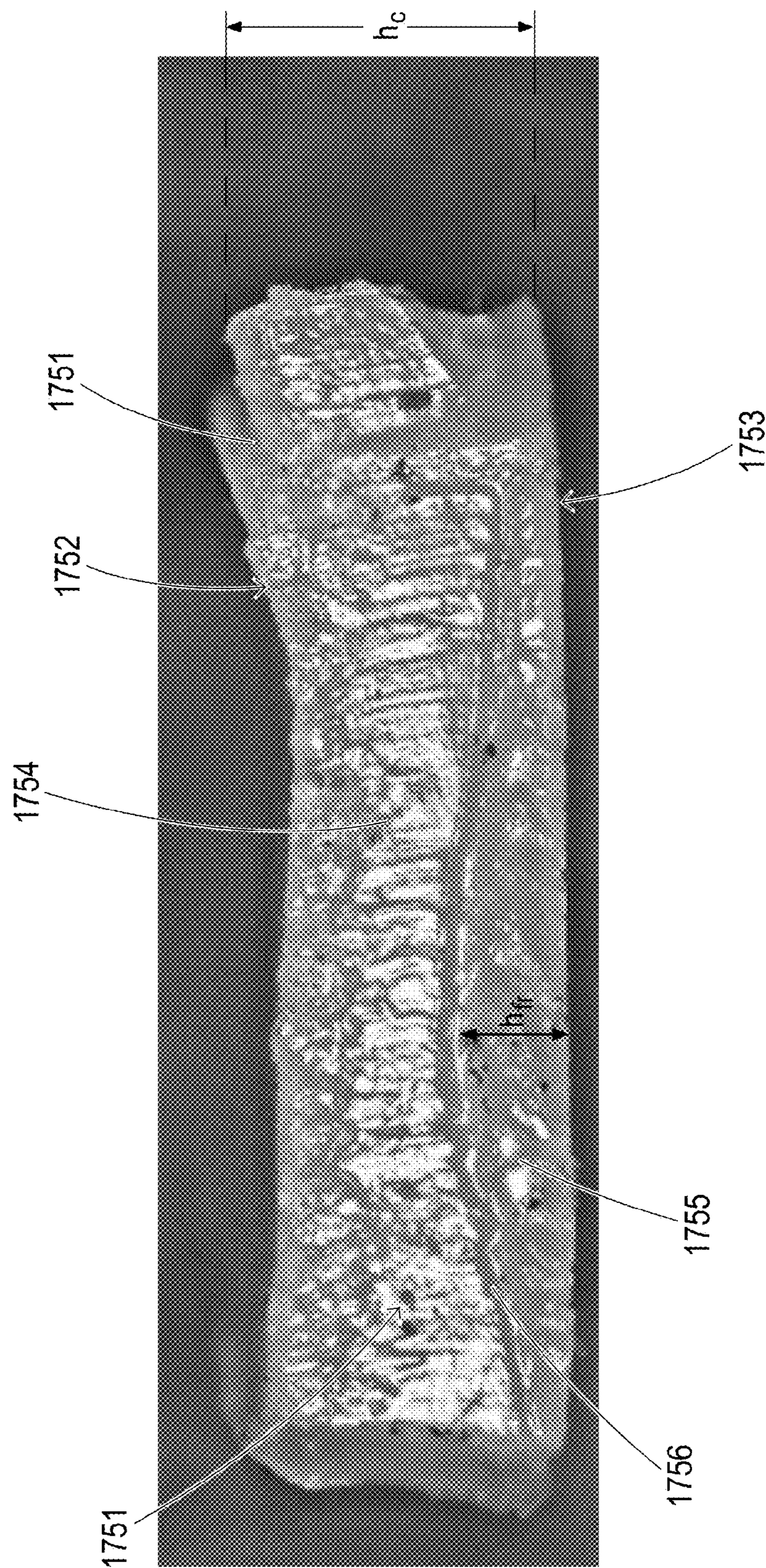


FIG. 17C



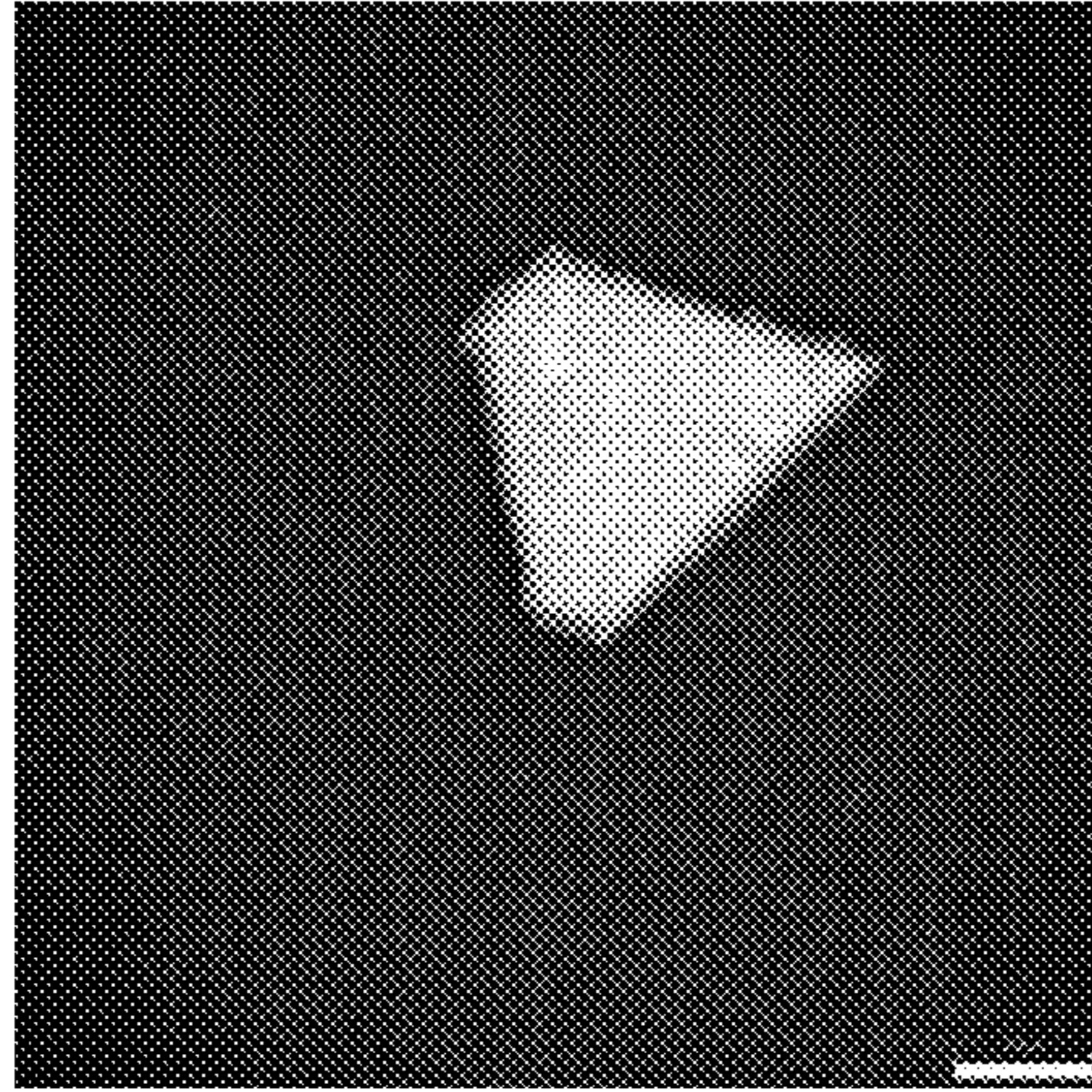


FIG. 18A

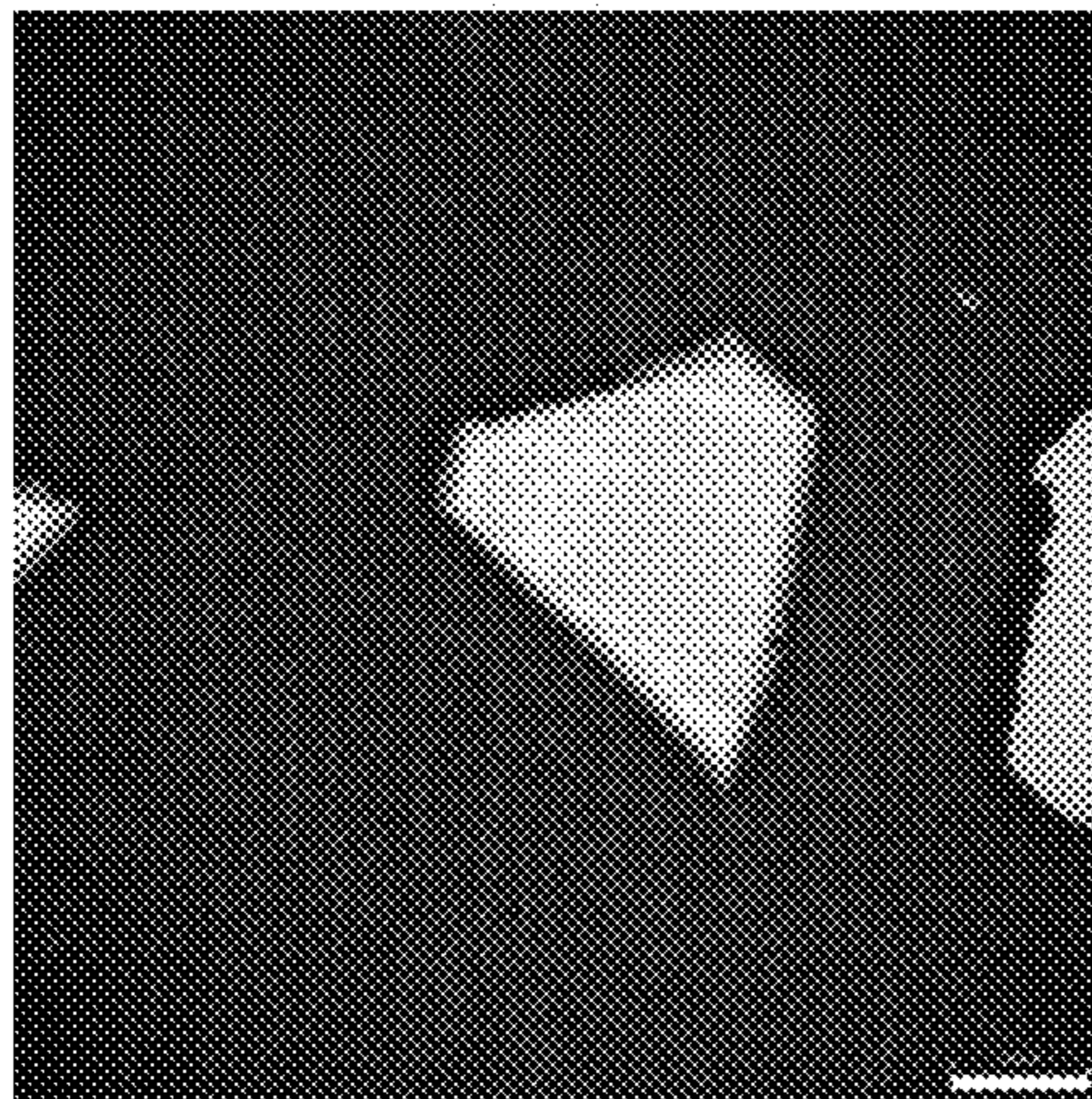


FIG. 18B

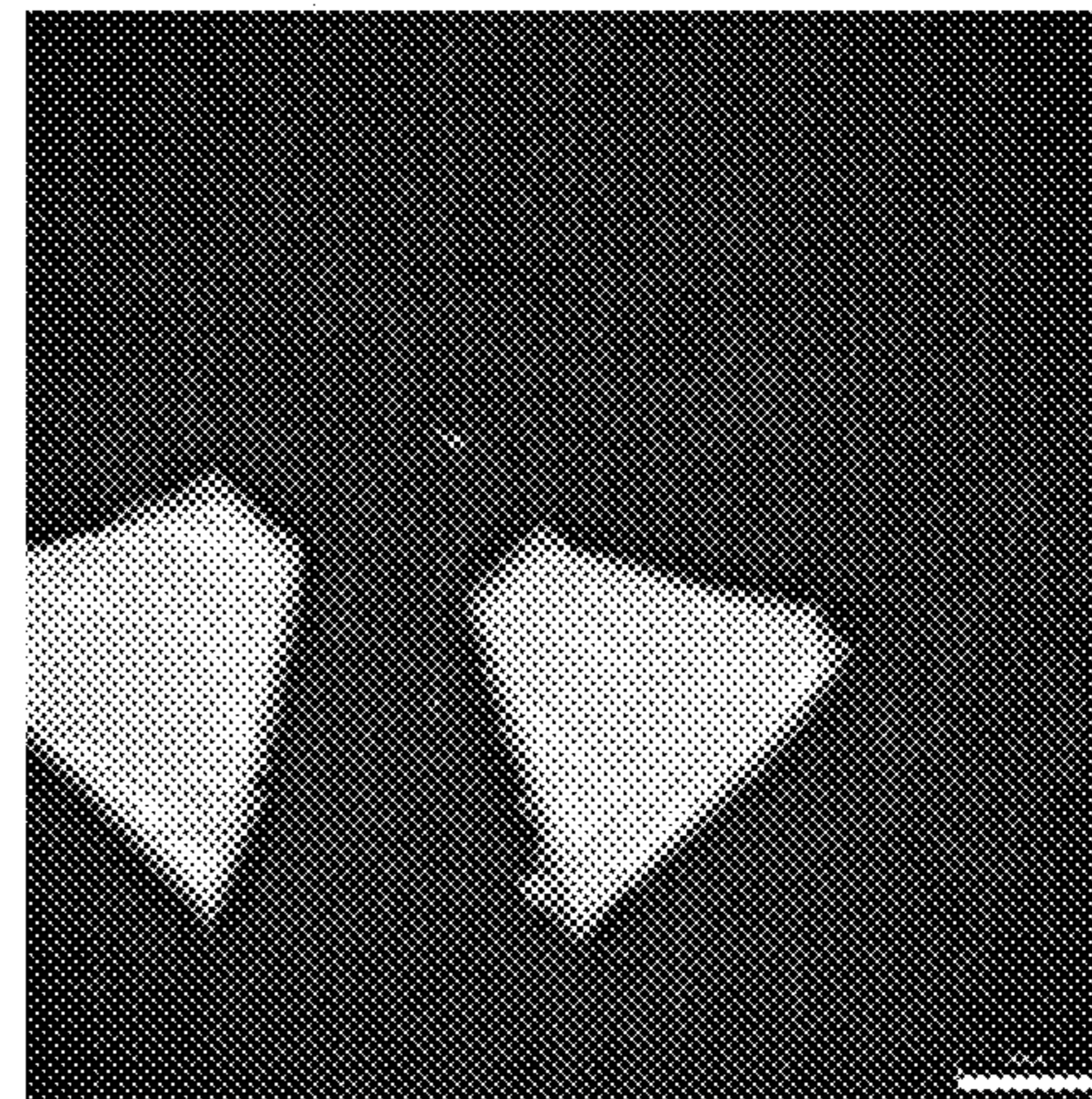


FIG. 18C

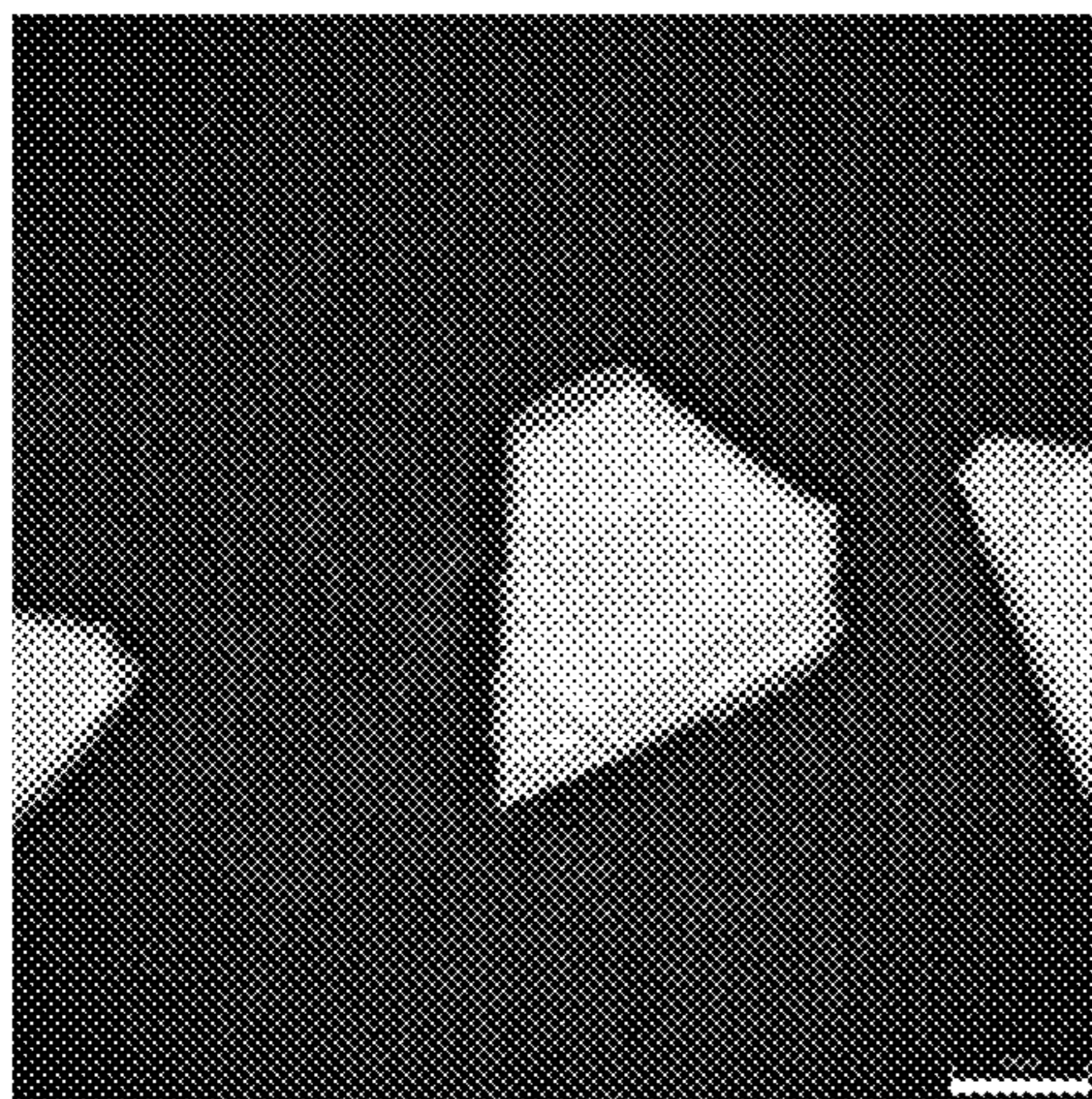


FIG. 18D

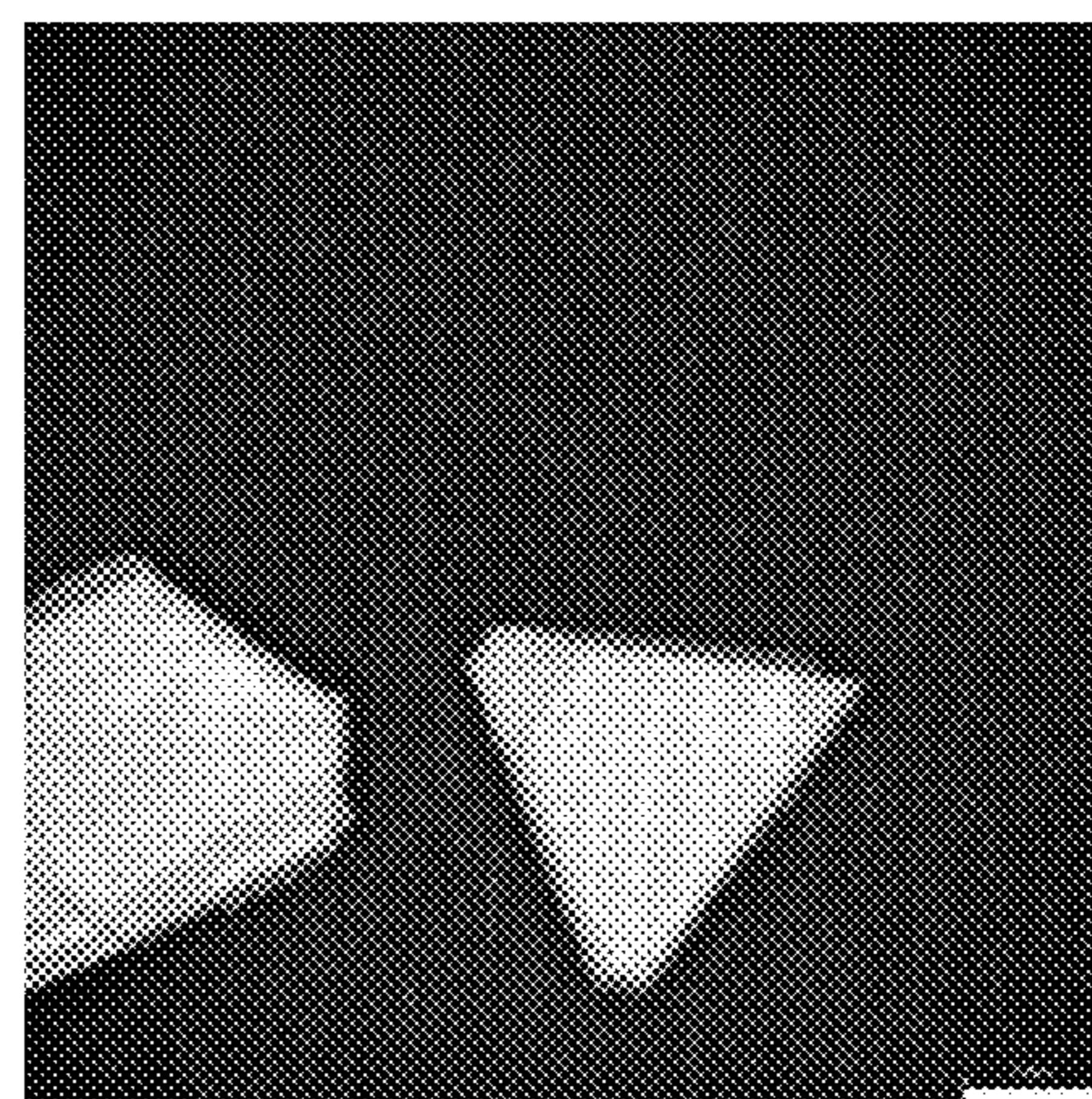


FIG. 18E



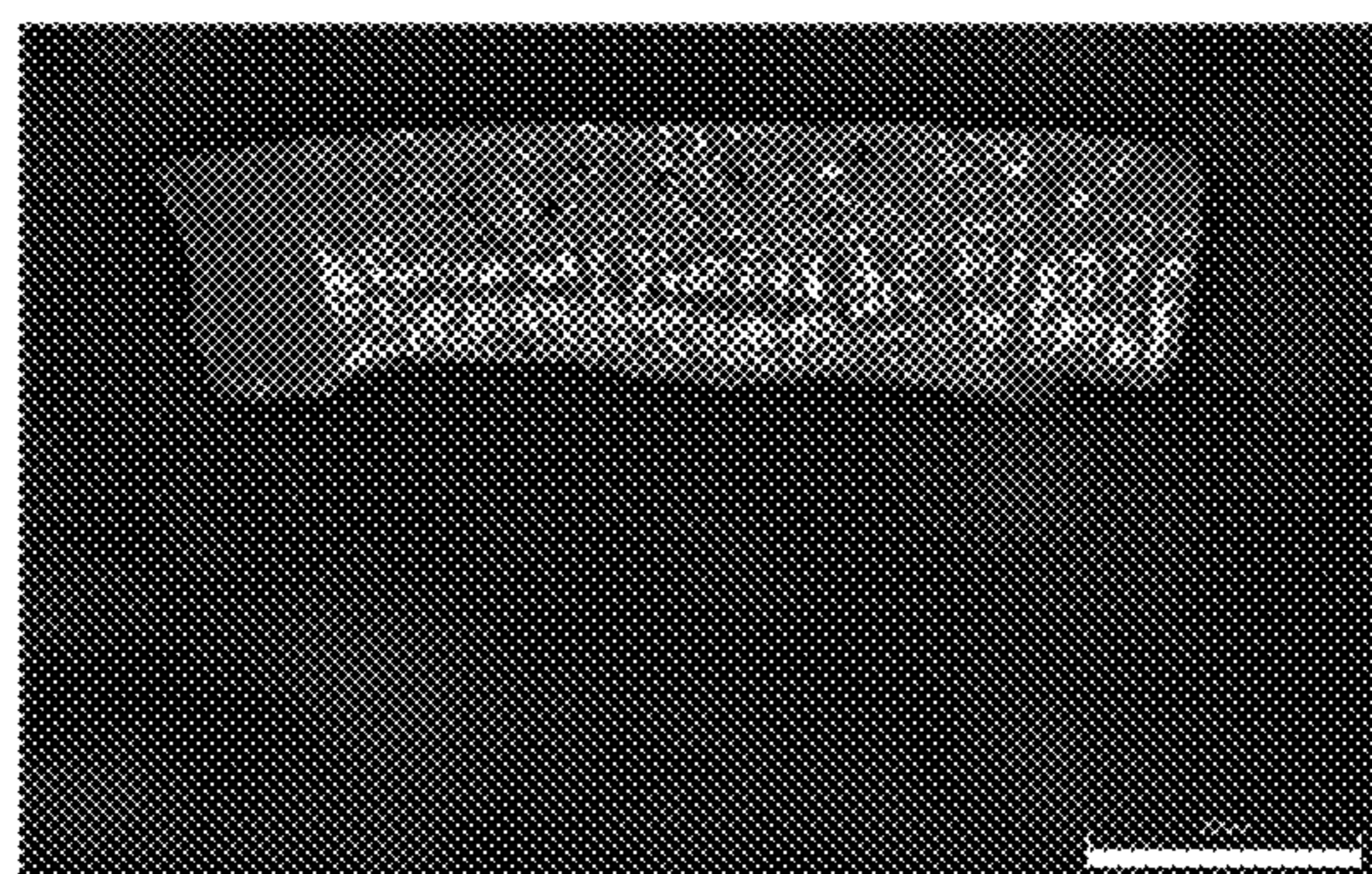


FIG. 19A



FIG. 19B

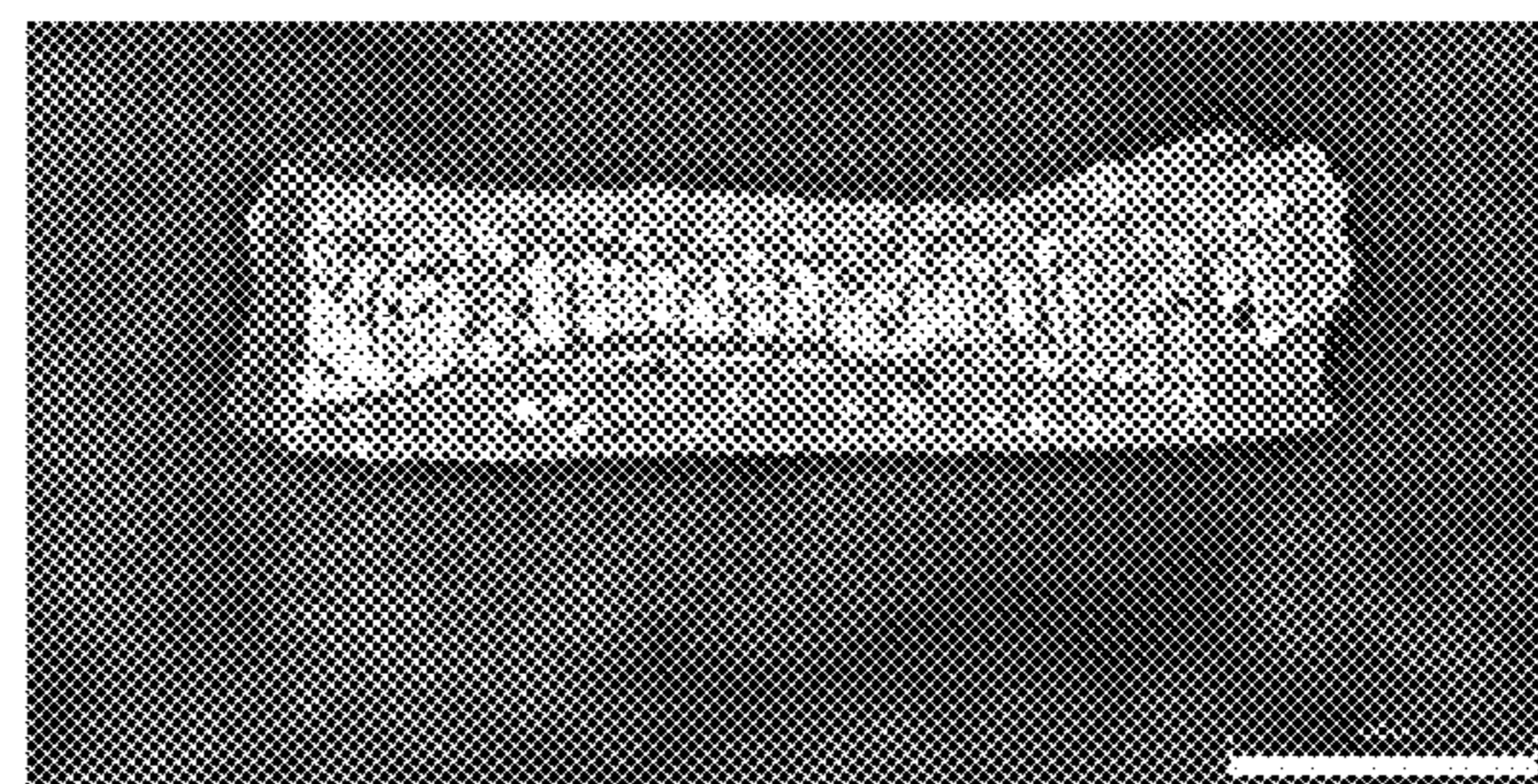


FIG. 19C

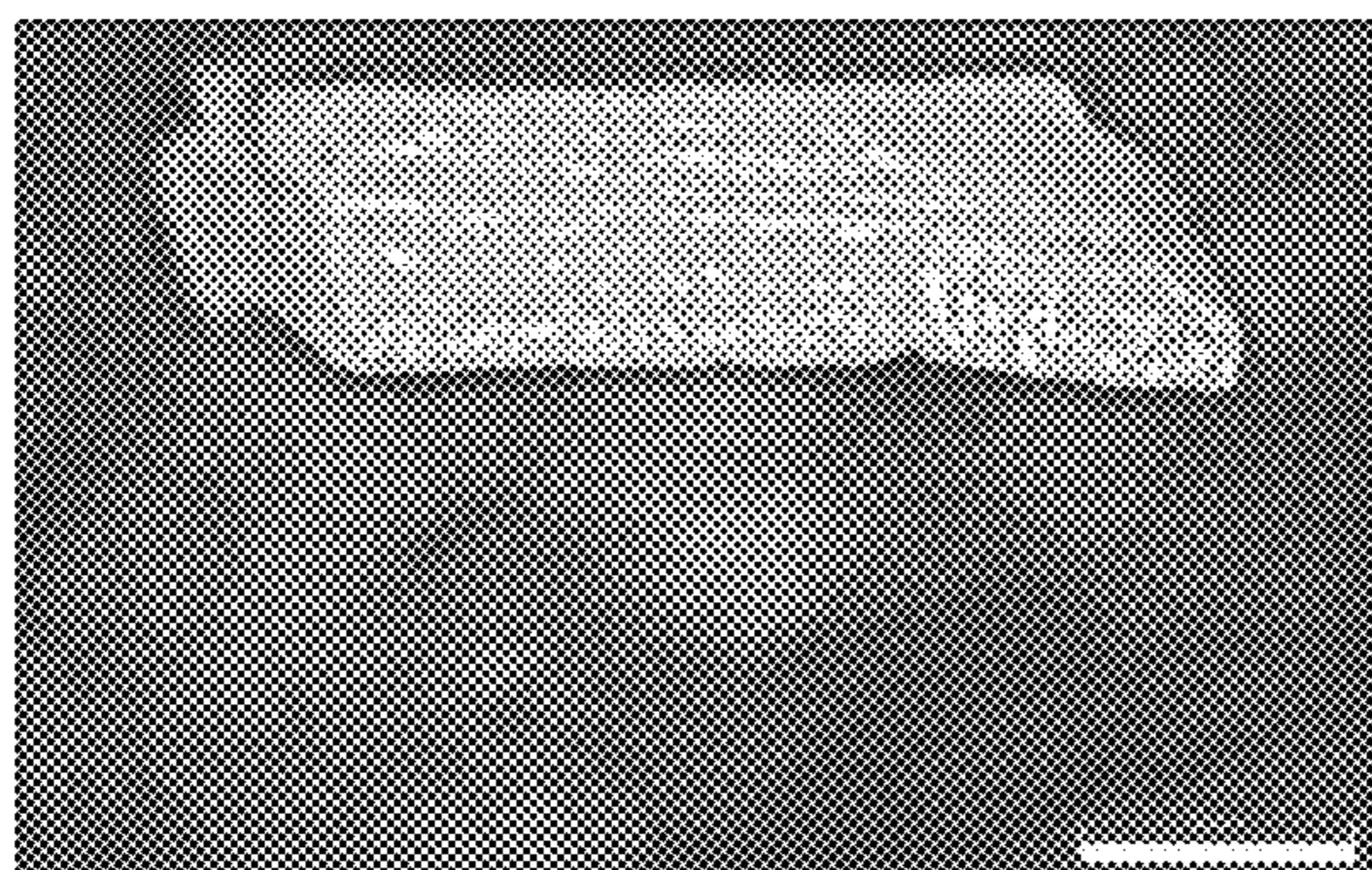


FIG. 19D

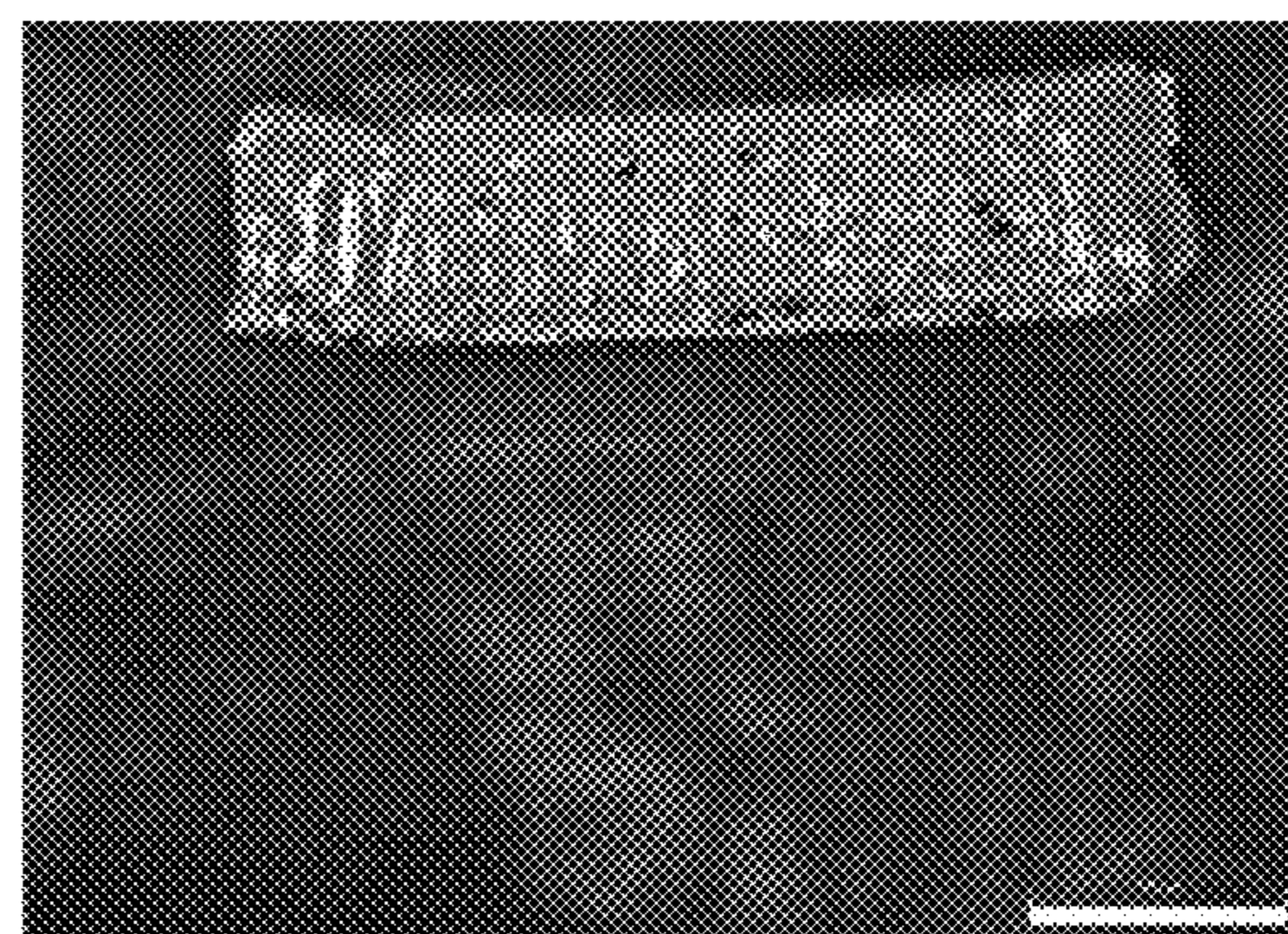


FIG. 19E



## SHAPED ABRASIVE PARTICLE AND METHOD OF FORMING SAME

### CROSS-REFERENCE TO RELATED APPLICATION(S)

The present application is a continuation of U.S. Non-Provisional application Ser. No. 13/731,810, filed Dec. 31, 2012, entitled "SHAPED ABRASIVE PARTICLE AND METHOD OF FORMING SAME," naming inventor Paul Braun et al., and claims priority from U.S. Provisional Patent Application No. 61/581,800, filed Dec. 30, 2011, entitled "SHAPED ABRASIVE PARTICLE AND METHOD OF FORMING SAME," naming inventor Paul Braun et al., which application is incorporated by reference herein in its entirety.

### BACKGROUND

#### Field of the Disclosure

The following is directed to shaped abrasive particles, and more particularly, to shaped abrasive particles having certain features and methods of forming such shaped abrasive particles.

#### Description of the Related Art

Abrasive articles incorporating abrasive particles are useful for various material removal operations including grinding, finishing, polishing, and the like. Depending upon the type of abrasive material, such abrasive particles can be useful in shaping or grinding various materials in the manufacturing of goods. Certain types of abrasive particles have been formulated to date that have particular geometries, such as triangular shaped abrasive particles and abrasive articles incorporating such objects. See, for example, U.S. Pat. Nos. 5,201,916; 5,366,523; and 5,984,988.

Previously, three basic technologies that have been employed to produce abrasive particles having a specified shape, which are fusion, sintering, and chemical ceramic. In the fusion process, abrasive particles can be shaped by a chill roll, the face of which may or may not be engraved, a mold into which molten material is poured, or a heat sink material immersed in an aluminum oxide melt. See, for example, U.S. Pat. No. 3,377,660. In sintering processes, abrasive particles can be formed from refractory powders having a particle size of up to 10 micrometers in diameter. Binders can be added to the powders along with a lubricant and a suitable solvent to form a mixture that can be shaped into platelets or rods of various lengths and diameters. See, for example, U.S. Pat. No. 3,079,242. Chemical ceramic technology involves converting a colloidal dispersion or hydrosol (sometimes called a sol) to a gel or any other physical state that restrains the mobility of the components, drying, and firing to obtain a ceramic material. See, for example, U.S. Pat. Nos. 4,744,802 and 4,848,041.

The industry continues to demand improved abrasive materials and abrasive articles.

### SUMMARY

According to a first aspect, a method of forming a shaped abrasive particle comprises forming a mixture comprising a ceramic material into a sheet, sectioning at least a portion of the sheet with a mechanical object, and forming a shaped abrasive particle from the mixture, wherein the shaped abrasive particle comprises a two-dimensional shape as viewed in a plane defined by a length and a width of the shaped abrasive particle selected from the group consisting

of polygons, ellipsoids, numerals, Greek alphabet characters, Latin alphabet characters, Russian alphabet characters, complex shapes having a combination of polygonal shapes, and a combination thereof.

In a second aspect, a particulate material comprises a batch of shaped abrasive particles comprising a first type of shaped abrasive particle comprising a length (l), a width (w), and a height (h), wherein the first type of shaped abrasive particle comprises a first polygonal shape as viewed in a plane defined by the length and width, a second type of shaped abrasive particle comprising a length (l), a width (w), and a height (h), wherein the second type of shaped abrasive particle comprises a second polygonal shape as viewed in a plane defined by the length and width, the second polygonal shape different than the first polygonal shape.

According to a third aspect, a particulate material comprises a shaped abrasive particle having a body comprising a corner-truncated polygonal shape including a first long side, a second long side, and a first short side disposed between the first long side and second long side having a length shorter than the first long side and shorter than the second long side, and a first angle between the first short side and the first long side greater than 90°.

In another aspect, a coated abrasive article includes a substrate, a first type of abrasive particulate material coupled to the substrate having a body comprising a length (l), a width (w), and a height (h), the first type of abrasive particulate material having a first polygonal shape as viewed in a plane defined by the length and width and a second type of shaped abrasive particle coupled to the substrate having a body comprising a length (l), a width (w), and a height (h), the second type of abrasive particulate material having a second polygonal shape as viewed in a plane defined by the length and width different than the first polygonal shape.

For another aspect, a particulate material includes a shaped abrasive particle having a body and including a first major surface, a second major surface, and a side surface extending between the first and second major surfaces, wherein the side surface has a ripple feature.

In yet another aspect, a batch of particulate material includes a first portion having a first type of shaped abrasive particle and a second portion including a second type of shaped abrasive particle having a body defining a length (l), a width (w), and a height (h), wherein the second type of shaped abrasive particle is different than the first type and includes a corner-truncated shape.

According to one aspect, a particulate material includes a shaped abrasive particle having a body including a first major surface, a second major surface, and at least one side surface extending between the first major surface and the second major surface, wherein the side surface has a fractured region intersecting at least a portion of an edge defining the second major surface.

In yet another aspect, a method of forming a shaped abrasive particle comprises forming a mixture comprising a ceramic material into a sheet, sectioning at least a portion of the sheet with a mechanical object, and maintaining the opening in the sheet after sectioning and forming a precursor shaped abrasive particle.

### BRIEF DESCRIPTION OF THE DRAWINGS

The present disclosure may be better understood, and its numerous features and advantages made apparent to those skilled in the art by referencing the accompanying drawings.



FIG. 1A includes a schematic of a method of forming a shaped abrasive particle in accordance with an embodiment; FIG. 1B includes a top view of the schematic shown in FIG. 1A.

FIG. 2 includes a particular device that can be used in forming a shaped abrasive particle in accordance with an embodiment.

FIG. 3 includes an illustration of a process of forming a shaped abrasive particle in accordance with an embodiment.

FIG. 4A includes a cross-sectional illustration of a process utilized in forming a shaped abrasive particle in accordance with an embodiment.

FIG. 4B includes a cross-sectional illustration of a portion of a sheet having an opening according to an embodiment.

FIG. 5 includes a cross-sectional illustration of a portion of a shaped abrasive particle in accordance with an embodiment.

FIG. 6 includes a cross-sectional illustration of a portion of a shaped abrasive particle in accordance with an embodiment.

FIG. 7A includes an illustration of a shaped abrasive particle in accordance with an embodiment.

FIGS. 7B and 7C include cross-sectional illustrations of a portion of the shaped abrasive particle of FIG. 7A.

FIGS. 8-13 include illustrations of shaped abrasive particles according to embodiments herein.

FIG. 14 includes a cross-sectional illustration of a coated abrasive article including shaped abrasive particles in accordance with an embodiment.

FIG. 15 includes an illustration of a bonded abrasive article including shaped abrasive particles in accordance with an embodiment.

FIG. 16A includes an illustration of a shaped abrasive particle according to an embodiment.

FIG. 16B includes a cross-sectional view of the shaped abrasive particle of FIG. 16A.

FIG. 16C includes a side-view of the shaped abrasive particle of FIG. 16A.

FIG. 17A includes a top-view image of a shaped abrasive particle according to an embodiment.

FIG. 17B includes a side-view image of the shaped abrasive particle of FIG. 17A.

FIG. 17C includes a side-view image of a shaped abrasive particle according to an embodiment.

FIG. 18A-18E include top-view images of shaped abrasive particles according to an embodiment.

FIG. 19A-19E include top-view images of shaped abrasive particles according to an embodiment.

#### DETAILED DESCRIPTION

The following is directed to methods of forming shaped abrasive particles and features of such shaped abrasive particles. The shaped abrasive particles may be used in various abrasive articles, including for example bonded abrasive articles, coated abrasive articles, and the like. Alternatively, the shaped abrasive particles of the embodiments herein may be utilized in free abrasive technologies, including for example grinding and/or polishing slurries.

FIG. 1 includes an illustration of a system for forming a shaped abrasive particle in accordance with an embodiment. The process of forming shaped abrasive particles can be initiated by forming a mixture 101 including a ceramic material and a liquid. In particular, the mixture 101 can be a gel formed of a ceramic powder material and a liquid, wherein the gel can be characterized as a shape-stable material having the ability to hold a given shape even in the

green (i.e., unfired) state. In accordance with an embodiment, the gel can include a powder material that is an integrated network of discrete particles.

The mixture 101 can be formed to have a particular content of solid material, such as the ceramic powder material. For example, in one embodiment, the mixture 101 can have a solids content of at least about 25 wt %, such as at least about 35 wt %, at least about 38 wt %, or even at least about 42 wt % for the total weight of the mixture 101. Still, in at least one non-limiting embodiment, the solid content of the mixture 101 can be not greater than about 75 wt %, such as not greater than about 70 wt %, not greater than about 65 wt %, or even not greater than about 55 wt %. It will be appreciated that the content of the solids materials in the mixture 101 can be within a range between any of the minimum and maximum percentages noted above.

According to one embodiment, the ceramic powder material can include an oxide, a nitride, a carbide, a boride, an oxycarbide, an oxynitride, and a combination thereof. In particular instances, the ceramic material can include alumina. More specifically, the ceramic material may include a boehmite material, which may be a precursor of alpha alumina. The term "boehmite" is generally used herein to denote alumina hydrates including mineral boehmite, typically being  $\text{Al}_2\text{O}_3 \cdot \text{H}_2\text{O}$  and having a water content on the order of 15%, as well as pseudoboehmite, having a water content higher than 15%, such as 20-38% by weight. It is noted that boehmite (including pseudoboehmite) has a particular and identifiable crystal structure, and accordingly unique X-ray diffraction pattern, and as such, is distinguished from other aluminous materials including other hydrated aluminas such as ATH (aluminum trihydroxide) a common precursor material used herein for the fabrication of boehmite particulate materials.

Furthermore, the mixture 101 can be formed to have a particular content of liquid material. Some suitable liquids may include organic materials, such as water. In accordance with one embodiment, the mixture 101 can be formed to have a liquid content less than the solids content of the mixture 101. In more particular instances, the mixture 101 can have a liquid content of at least about 25 wt % for the total weight of the mixture 101. In other instances, the amount of liquid within the mixture 101 can be greater, such as at least about 35 wt %, at least about 45 wt %, at least about 50 wt %, or even at least about 58 wt %. Still, in at least one non-limiting embodiment, the liquid content of the mixture can be not greater than about 75 wt %, such as not greater than about 70 wt %, not greater than about 65 wt %, not greater than about 60 wt %, or even not greater than about 55 wt %. It will be appreciated that the content of the liquid in the mixture 101 can be within a range between any of the minimum and maximum percentages noted above.

Furthermore, to facilitate processing and forming shaped abrasive particles according to embodiments herein, the mixture 101 can have a particular storage modulus. For example, the mixture 101 can have a storage modulus of at least about  $1 \times 10^4$  Pa, such as at least about  $4 \times 10^4$  Pa, or even at least about  $5 \times 10^4$  Pa. However, in at least one non-limiting embodiment, the mixture 101 may have a storage modulus of not greater than about  $1 \times 10^7$  Pa, such as not greater than about  $1 \times 10^6$  Pa. It will be appreciated that the storage modulus of the mixture 101 can be within a range between any of the minimum and maximum values noted above. The storage modulus can be measured via a parallel plate system using ARES or AR-G2 rotational rheometers, with Peltier plate temperature control systems. For testing, the mixture 101 can be extruded within a gap between two



plates that are set to be approximately 8 mm apart from each other. After extruding the get into the gap, the distance between the two plates defining the gap is reduced to 2 mm until the mixture **101** completely fills the gap between the plates. After wiping away excess mixture, the gap is 5 decreased by 0.1 mm and the test is initiated. The test is an oscillation strain sweep test conducted with instrument settings of a strain range between 0.1% to 100%, at 6.28 rad/s (1 Hz), using 25-mm parallel plate and recording 10 points per decade. Within 1 hour after the test completes, 10 lower the gap again by 0.1 mm and repeat the test. The test can be repeated at least 6 times. The first test may differ from the second and third tests. Only the results from the second and third tests for each specimen should be reported. The viscosity can be calculated by dividing the storage modulus 15 value by 6.28 s<sup>-1</sup>.

Furthermore, to facilitate processing and forming shaped abrasive particles according to embodiments herein, the mixture **101** can have a particular viscosity. For example, the mixture **101** can have a viscosity of at least about 4×10<sup>3</sup> Pa s, at least about 5×10<sup>3</sup> Pa s, at least about 6×10<sup>3</sup> Pa s, at least about 8×10<sup>3</sup> Pa s, at least about 10×10<sup>3</sup> Pa s, at least about 20×10<sup>3</sup> Pa s, at least about 30×10<sup>3</sup> Pa s, at least about 40×10<sup>3</sup> Pa s, at least about 50×10<sup>3</sup> Pa s, at least about 60×10<sup>3</sup> Pa s, or even at least about 65×10<sup>3</sup> Pa s. In at least one non-limiting embodiment, the mixture **101** may have a viscosity of not greater than about 1×10<sup>6</sup> Pa s, not greater than about 5×10<sup>5</sup> Pa s, not greater than about 3×10<sup>5</sup> Pa s, or even not greater than about 2×10<sup>5</sup> Pa s. It will be appreciated that the viscosity of the mixture **101** can be within a range between 20 any of the minimum and maximum values noted above.

Moreover, the mixture **101** can be formed to have a particular content of organic materials, including for example, organic additives that can be distinct from the liquid, to facilitate processing and formation of shaped abrasive particles according to the embodiments herein. Some suitable organic additives can include stabilizers, binders, such as fructose, sucrose, lactose, glucose, UV curable resins, and the like. 25

Notably, the embodiments herein may utilize a mixture **101** that is distinct from slurries used in conventional tape casting operations. For example, the content of organic materials within the mixture **101**, particularly, any of the organic additives noted above may be a minor amount as compared to other components within the mixture **101**. In at least one embodiment, the mixture **101** can be formed to have not greater than about 30 wt % organic material for the total weight of the mixture **101**. In other instances, the amount of organic materials may be less, such as not greater than about 15 wt %, not greater than about 10 wt %, or even not greater than about 5 wt %. Still, in at least one non-limiting embodiment, the amount of organic materials within the mixture **101** can be at least about 0.1 wt %, such as at least about 0.5 wt % for the total weight of the mixture **101**. It will be appreciated that the amount of organic materials in the mixture **101** can be within a range between 30 any of the minimum and maximum values noted above.

Moreover, the mixture **101** can be formed to have a particular content of acid or base distinct from the liquid, to facilitate processing and formation of shaped abrasive particles according to the embodiments herein. Some suitable acids or bases can include nitric acid, sulfuric acid, citric acid, chloric acid, tartaric acid, phosphoric acid, ammonium nitrate, ammonium citrate. According to one particular embodiment, the mixture **101** can have a pH of less than 35 about 5, and more particularly, within a range between about 2 and about 4, using a nitric acid additive.

Referencing FIG. 1, the system **100** can include a die **103**. As illustrated, the mixture **101** can be provided within the interior of the die **103** and configured to be extruded through a die opening **105** positioned at one end of the die **103**. As 5 further illustrated, forming can include applying a force **180** (that may be translated into a pressure) on the mixture **101** to facilitate moving the mixture **101** through the die opening **105**. In accordance with an embodiment, a particular pressure may be utilized during extrusion. For example, the pressure can be at least about 10 kPa, such as at least about 500 kPa. Still, in at least one non-limiting embodiment, the pressure utilized during extrusion can be not greater than about 4 MPa. It will be appreciated that the pressure used to extrude the mixture **101** can be within a range between any 10 of the minimum and maximum values noted above.

In certain systems, the die **103** can include a die opening **105** having a particular shape. It will be appreciated that the die opening **105** may be shaped to impart a particular shape to the mixture **101** during extrusion. In accordance with an embodiment, the die opening **105** can have a rectangular shape. Furthermore, the mixture **101** extruded through the die opening **105** can have essentially the same cross-sectional shape as the die opening **105**. As further illustrated, the mixture **101** may be extruded in the form of a sheet **111** and onto a belt **109** underlying the die **103**. In specific instances, the mixture **101** can be extruded in the form of a sheet **111** directly onto the belt **109**, which may facilitate continuous processing. 25

According to one particular embodiment, the belt can be formed to have a film overlying a substrate, wherein the film can be a discrete and separate layer of material configured to facilitate processing and forming of shaped abrasive particles. The process can include providing the mixture **101** directly onto the film of the belt to form the sheet **111**. In certain instances, the film can include a polymer material, such as polyester. In at least one particular embodiment, the film can consist essentially of polyester. 30

In some embodiments, the belt **109** can be translated while moving the mixture **101** through the die opening **105**. As illustrated in the system **100**, the mixture **101** may be extruded in a direction **191**. The direction of translation **110** of the belt **109** can be angled relative to the direction of extrusion **191** of the mixture. While the angle between the direction of translation **110** and the direction of extrusion **191** are illustrated as substantially orthogonal in the system **100**, other angles are contemplated, including for example, an acute angle or an obtuse angle. Moreover, while the mixture **101** is illustrated as being extruded in a direction **191**, which is angled relative to the direction of translation **110** of the belt **109**, in an alternative embodiment, the belt **109** and mixture **101** may be extruded in substantially the same direction. 35

The belt **109** may be translated at a particular rate to facilitate processing. For example, the belt **109** may be translated at a rate of at least about 3 cm/s. In other embodiments, the rate of translation of the belt **109** may be greater, such as at least about 4 cm/s, at least about 6 cm/s, at least about 8 cm/s, or even at least about 10 cm/s. Still, in at least one non-limiting embodiment, the belt **109** may be translated in a direction **110** at a rate of not greater than about 5 m/s, not greater than about 1 m/s, or even not greater than about 0.5 m/s. It will be appreciated that the screen **151** may be translated at a rate within a range between any of the minimum and maximum values noted above. 40

For certain processes according to embodiments herein, the rate of translation of the belt **109** as compared to the rate of extrusion of the mixture **101** in the direction **191** may be 45



controlled to facilitate proper processing. For example, the rate of translation of the belt 109 can be essentially the same as the rate of extrusion to ensure formation of a suitable sheet 111.

After the mixture 101 is extruded through the die opening 105, the mixture 101 may be translated along the belt 109 under a knife edge 107 attached to a surface of the die 103. The knife edge 107 may facilitate forming a sheet 111. More particularly, the opening defined between the surface of the knife edge 107 and belt 109 may define particular dimensions of the extruded mixture 101. For certain embodiments, the mixture 101 may be extruded in the form of a sheet 111 having a generally rectangular cross-sectional shape as viewed in a plane defined by a height and width of the sheet 111. While the extrudate is illustrated as a sheet, other shapes can be extruded, including for example cylindrical shapes and the like.

The process of forming the sheet 111 from the mixture 101 can include control of particular features and process parameters to facilitate suitable formation of shaped abrasive particles having one or more features as provided in the embodiments herein. For example, in certain instances, the process of forming a sheet 111 from the mixture 101 can include forming a sheet 111 having a particular height 181 controlled in part by a distance between the knife edge 107 and a surface of the belt 109. Moreover, it is noted that the height 181 of the sheet 111 can be controlled by varying a distance between the knife edge 107 and the surface of the belt 109. Additionally, forming the mixture 101 into the sheet 111 can include controlling the dimensions of the sheet 111 based in part upon the viscosity of the mixture 101. In particular, forming the sheet 111 can include adjusting the height 181 of the sheet 111 based on the viscosity of the mixture 101.

Furthermore, to facilitate processing and forming shaped abrasive particles according to embodiments herein, the mixture 101, and thus the sheet 111, can have a particular viscosity. For example, the mixture 101 can have a viscosity of at least about  $4 \times 10^3$  Pa s, at least about  $5 \times 10^3$  Pa s, at least about  $6 \times 10^3$  Pa s, at least about  $8 \times 10^3$  Pa s, at least about  $10 \times 10^3$  Pa s, at least about  $20 \times 10^3$  Pa s, at least about  $30 \times 10^3$  Pa s, at least about  $40 \times 10^3$  Pa s, at least about  $50 \times 10^3$  Pa s, at least about  $60 \times 10^3$  Pa s, or even at least about  $65 \times 10^3$  Pa s. In at least one non-limiting embodiment, the mixture 101 may have a viscosity of not greater than about  $1 \times 10^6$  Pa s, not greater than about  $5 \times 10^5$  Pa s, not greater than about  $3 \times 10^5$  Pa s, or even not greater than about  $2 \times 10^5$  Pa s. It will be appreciated that the viscosity of the mixture 101 can be within a range between any of the minimum and maximum values noted above. The viscosity can be measured in the same manner as the storage modulus as described above.

The sheet 111 can have particular dimensions, including for example a length (l), a width (w), and a height (h). In accordance with an embodiment, the sheet 111 may have a length that extends in the direction of the translating belt 109, which can be greater than the width, wherein the width of the sheet 111 is a dimension extending in a direction perpendicular to the length of the belt 109 and to the length of the sheet. The sheet 111 can have a height 181, wherein the length and width are greater than the height 181 of the sheet 111.

Notably, the height 181 of the sheet 111 can be the dimension extending vertically from the surface of the belt 109. In accordance with an embodiment, the sheet 111 can be formed to have a particular dimension of height 181, wherein the height may be an average height of the sheet 111 derived from multiple measurements. For example, the

height 181 of the sheet 111 can be at least about 0.1 mm, such as at least about 0.5 mm. In other instances, the height 181 of the sheet 111 can be greater, such as at least about 0.8 mm, at least about 1 mm, at least about 1.2 mm, at least about 1.6 mm, or even at least about 2 mm. Still, in one non-limiting embodiment, the height 181 of the sheet 111 may be not greater than about 10 mm, not greater than about 5 mm, or even not greater than about 2 mm. It will be appreciated that the sheet 111 may have an average height within a range between any of the minimum and maximum values noted above.

According to one embodiment, the sheet 111 can have a length (l), a width (w), and a height (h), wherein the length  $\geq$  width  $\geq$  height. Moreover, the sheet 111 can have a secondary aspect ratio of length:height of at least about 10, such as at least about 100, at least about 1000, or even at least about 1000.

After extruding the mixture 101 from the die 103, the sheet 111 may be translated in a direction 112 along the surface of the belt 109. Translation of the sheet 111 along the belt 109 may facilitate further processing to form precursor shaped abrasive particles. For example, the sheet 111 may undergo a shaping process within the shaping zone 113. In particular instances, the process of shaping can include shaping a surface of the sheet 111, including for example, an upper major surface 117 of the sheet 111. In other embodiments, other major surfaces of the sheet may undergo shaping, including for example, the bottom surface or side surfaces. For certain processes, shaping can include altering a contour of the sheet through one or more processes, such as, embossing, rolling, cutting, engraving, patterning, stretching, twisting, and a combination thereof.

In one particular embodiment, the process of shaping can include forming a feature 119 in the upper major surface 117 of the sheet 111. More particularly, a shaping structure 115 may be contacted to the upper major surface 117 of the sheet 111 facilitating the formation of a feature 119 or a pattern of features in the upper major surface 117. It will be appreciated that the shaping structure 115 can take various forms, including for example, a roller having various features on its surface, wherein such features may be imparted to the upper major surface 117 of the sheet 111 upon contact between the shaping structure 115 and the upper major surface 117.

Still, it will be appreciated that alternative shaping structures and methods of shaping a sheet may be utilized. For example, the surface of the belt 109 may be textured such that features of the texture are imparted to the sheet 111, and the finally-formed shaped abrasive particles. Moreover, various devices may be used to impart a feature or pattern of features on the side surfaces of the sheet 111.

In accordance with an embodiment, the process of forming a shaped abrasive particle can further include translation of the sheet along the belt 109 through a forming zone 121. In accordance with an embodiment, the process of forming a shaped abrasive particle can include sectioning the sheet 111 to form precursor shaped abrasive particles 123. For example, in certain instances, forming can include perforating a portion of the sheet 111. In other instances, the process of forming can include patterning the sheet 111 to form a patterned sheet and extracting shapes from the patterned sheet.

Particular processes of forming can include cutting, pressing, punching, crushing, rolling, twisting, bending, drying, and a combination thereof. In one embodiment, the process of forming can include sectioning of the sheet 111. Sectioning of the sheet 111 can include the use of at least one mechanical object, which may be in the form of a gas, liquid,



or solid material. The process of sectioning can include at least one or a combination of cutting, pressing, punching, crushing, rolling, twisting, bending, and drying. Moreover, it will be appreciated that sectioning can include perforating or creating a partial opening through a portion of the sheet **111**, which may not extend through the entire height of the sheet **111**.

For example, sectioning can include a water jet cutting process. In another embodiment, sectioning of the sheet **111** can include use of a mechanical object including one or a plurality of a blade, a wire, a disc, and a combination thereof. The blades may be oriented relative to each other in a variety of configurations to achieve the desired sectioning. For example, the blades may be arranged parallel to each other, such as in a gang configuration. Alternatively, the mechanical object may include a set of spiral blades connected to each other or independent of each other.

Alternatively, the process of forming shaped abrasive particles can include the use of radiation to section the sheet **111** into discrete precursor shaped abrasive particles. For example, use of radiation may include the use of a laser to score or otherwise cut discrete shaped abrasive particles from the sheet **111**.

It will be appreciated that at least one blade may be translated through the sheet **111** to facilitate sectioning. In particular instances, a sectioning process using a blade can include translating a blade in multiple directions including a first direction, and a second direction different than the first direction through the sheet **111**. More notably, certain sectioning processes may utilize a plurality of blades that can be translated across and through the sheet **111** in multiple directions to facilitate the formation of precursor shaped abrasive particles **123**.

FIG. 2 includes an illustration of a particular device that may be utilized within the forming zone **121** to facilitate sectioning. As illustrated, the process of sectioning may include use of a cutting device **201** having a plurality of blades **202**, **203**, **204**, **205**, and **206** arranged in parallel to each other. The cutting device **201** can be translated in multiple directions through the sheet **111** to facilitate the formation of precursor shaped abrasive particles **123**. For example, as illustrated in FIG. 2, the cutting device **201** may be translated first in a direction **207** angled with respect to the length (l) of the sheet **111**. Thereafter, the cutting device **201** may be translated in a second direction **209** different than the first direction **207** and angled with respect to the first direction **207**. Finally, the cutting device **201** may be translated across and through the sheet **111** in a third direction **208** that is different than the first direction **207** or second direction **209** to facilitate the formation of precursor shaped abrasive particles. While reference herein has noted that a single cutting device **201** may be translated in multiple directions, it will be appreciated that individual cutting devices may be utilized for discrete and individual cutting directions.

The process of sectioning can create different types of shaped abrasive particles in a single sectioning process. Different types of shaped abrasive particles can be formed from the same processes of the embodiments herein. Different types of shaped abrasive particles include a first type of shaped abrasive particle having a first two-dimensional shape and a second type of shaped abrasive particle having a different two-dimensional shape as compared to the first two-dimensional shape. Furthermore, different types of shaped abrasive particles may differ from each other in size. For example, different types of shaped abrasive particles may have different volumes as compared to each other. A

single process which is capable of forming different types of shaped abrasive particles may be particularly suited for producing certain types of abrasive articles.

As further illustrated, upon sectioning of the sheet **111** with a cutting device **201**, a plurality of precursor shaped abrasive particles may be formed in the sheet **111**. In particular instances, as illustrated in FIG. 2, a first type of precursor shaped abrasive particles **240** can be formed from the sheet **111**. The precursor shaped abrasive particles **240** may have a generally triangular shape two-dimensional shape as viewed in a plane defined by the length (l) and width (w) of the sheet **111**.

Furthermore, the sectioning process may form another type of precursor shaped abrasive particles **243** approximate to, and even abutting, the edge of the sheet **111**. The precursor shaped abrasive particles **243** can have a triangular two-dimensional shape as viewed in a plane defined by the length (l) and width (w) of the sheet **111**. However, the precursor shaped abrasive particles **243** can be smaller in size as compared to the precursor shaped abrasive particles **240**. In particular instances, the precursor shaped abrasive particles **243** can have a volume that is not greater than about 95% of the volume of the precursor shaped abrasive particles **240**. Volume may be an average value calculated by the measurement of volume for at least 20 shaped abrasive particles of the same type. In other instances, the precursor shaped abrasive particles **243** can have a volume that is not greater than about 92%, not greater than about 90%, not greater than about 85%, such as not greater than about 80%, not greater than about 75%, not greater than about 60%, or even not greater than about 50% of the volume of the precursor shaped abrasive particles **240**. Still, in one non-limiting embodiment, the precursor shaped abrasive particles **243** can have a volume that is at least about 10%, such as at least about 20%, at least about 30%, or even at least about 40% of the volume of the precursor shaped abrasive particles **240**. The difference in volume between the precursor shaped abrasive particles **243** and precursor shaped abrasive particles **240** can be within a range between any of the minimum and maximum percentages noted above.

Another type of precursor shaped abrasive particles **242** may be formed in the same sectioning process used to form the precursor shaped abrasive particles **240** and **243** from the sheet **111**. Notably, the precursor shaped abrasive particles **242** can have a quadrilateral two-dimensional shape as viewed in a plane defined by the width (w) and length (l) of the sheet **111**. According to one particular embodiment, the precursor shaped abrasive particles **242** may have a two-dimensional shape of a parallelogram. It will be appreciated that the precursor shaped abrasive particles **242** can have a difference in volume as compared to the other precursor shaped abrasive particles as described in other embodiments herein.

The sectioning process may create another type of shaped abrasive particle **244** used to form the precursor shaped abrasive particles **240**, **242**, and **243** from the same sheet **111**. Notably, the precursor shaped abrasive particles **244** can have a different two-dimensional polygonal shape as compared to the precursor shaped abrasive particles **240**, **242**, or **243**. As illustrated in the embodiment of FIG. 2, the precursor shaped abrasive particles **244** can have a quadrilateral shape, and more particularly, a trapezoidal shape, as viewed in a plane defined by the width (w) and length (l) of the sheet **111**. It will be appreciated that the precursor shaped abrasive particles **244** can have a difference in volume as compared to the other precursor shaped abrasive particles as described in other embodiments herein.



## 11

FIG. 3 includes an illustration of a portion of a sheet after a sectioning process in accordance with an embodiment. Notably, the sheet **111** can be cut in a first direction **308**, and subsequently cut in a second direction **307** at an angle relative to the first direction **308**. The sectioning process can create precursor shaped abrasive particles **321** having a generally quadrilateral polygonal shape as viewed in the plane defined by the length and width of the sheet **111**. Furthermore, depending upon the sectioning process, a different type of precursor shaped abrasive particles **322** can be created in the same sectioning process used to create the precursor shaped abrasive particles **321**. Notably, the precursor shaped abrasive particles **322** can be a different as compared to the precursor shaped abrasive particles **321** in terms of two-dimensional shape, size, and a combination thereof. For example, the precursor shaped abrasive particles **322** can have a greater volume as compared to the precursor shaped abrasive particles **321**.

FIG. 4 includes a cross-sectional illustration of a portion of a sheet that has been formed into precursor shaped abrasive particles in accordance with an embodiment. Notably, as illustrated in FIG. 4, the precursor shaped abrasive particle **123** can be formed to have particular contours of side surfaces **401** and **403**. In accordance with an embodiment, the precursor shaped abrasive particle **123** can have a first side surface **401** formed at a particular angle **405** to the upper surface **402**. Likewise, the side surface **403** of the precursor shaped abrasive particle **123** can be joined to the upper surface **402** at a particular angle **406**. Notably, the precursor shaped abrasive particle **123** can be formed such that the angle **405** formed between sidewall **401** and upper surface **402** can be different than the angle **406** formed between the sidewall **403** and upper surface **402**. Various methods of forming shaped abrasive particles **123** having different angles **405** and **406** can include those methods described herein. In certain instances, a sectioning device may be angled relative to the upper major surface of the sheet to facilitate removal of the material at an angle relative to the plane of the belt and plane of the upper surface of each precursor shaped abrasive particle **123**.

Sectioning can include moving the mechanical object through a portion of a sheet **111** and creating an opening within the sheet **111**. Referring briefly to FIG. 4B, a cross-sectional illustration of a portion of a sheet after sectioning according to an embodiment is provided. In particular, the sheet **111** has an opening **415** extending into the volume of the sheet **111** and defined by surfaces **416** and **417**. The opening **415** can define a cut extending through at least a fraction of the entire height (h) of sheet **111**. It will be appreciated that the opening **415** does not necessarily need to extend through the full height of the sheet **111**, and in particular instances, it may be suitable that the opening **409** in the sheet **111** is formed such that it does not extend through the entire height of the sheet **111**.

In certain instances, the method of sectioning can include maintaining the opening **415** in the sheet **111**. Maintaining the opening **415** after sectioning the sheet **111** has been sectioned by a mechanical object may facilitate suitable formation of shaped abrasive particles and features of shaped abrasive particles and features of a batch of shaped abrasive particles. Maintaining the opening **415** can include at least partially drying at least one surface of the sheet **111** defining the opening **415**, including for example, one of the surfaces **416** and **417**. The process of at least partially drying can include directing a drying material at the opening **415**.

## 12

A drying material may include a liquid, a solid, or even a gas. According to one particular embodiment, the drying material can include air.

Furthermore, the process of maintaining the opening **415** can include selectively directing a drying material, such as a gas, at the opening **415** and limiting the impingement of gas on other surfaces of the sheet **111**, such as the surfaces **418** and **419** substantially spaced apart from the opening **415**.

In certain instances, the process of sectioning can be conducted prior to sufficient drying of the sheet. For example, sectioning can be conducted prior to volatilization of not greater than about 20% of the liquid from the sheet **111** as compared to the original liquid content of the sheet during initial formation of the sheet **111**. In other embodiments, the amount of volatilization allowed to occur before or during sectioning can be less, such as, not greater than about 15%, not greater than about 12%, not greater than about 10%, not greater than about 8%, or even not greater than about 4% of the original liquid content of the sheet.

As indicated by the description of embodiments herein, sectioning can be conducted simultaneously with the process of forming. Moreover, sectioning can be conducted continuously during the process of forming. Sectioning may not necessarily include a change in composition to the sheet, such as in the case of ablation processes, which rely upon vaporization.

According to one embodiment, sectioning can be conducted at particular conditions to facilitate the forming process. For example, sectioning can be conducted at controlled sectioning conditions including at least one of a controlled humidity, a controlled temperature, a controlled air pressure, a controlled air flow, a controlled environmental gas composition, and a combination thereof. Control of such conditions may facilitate control of the drying of the sheet and facilitate formation of shaped abrasive particles having particular features. According to a particular embodiment, sectioning can include monitoring and control of one or more certain environmental conditions, including but not limited to humidity, temperature, air pressure, air flow, environmental gas composition, and a combination thereof.

For at least one embodiment, the temperature of the environment used for sectioning (i.e., sectioning temperature) that can be controlled relative to the temperature of the environment used in other processes. For example, the sectioning temperature can be conducted at a substantially different temperature as compared to the temperature used during forming (e.g., extruding) of the sheet. Alternatively, the temperature used during forming of the sheet can be substantially the same as the sectioning temperature. Moreover, in another embodiment, the mechanical object can have a temperature greater than a temperature of the sheet **111** during sectioning. In an alternative condition, the mechanical object can have a temperature less than a temperature of the sheet **111**.

For another aspect, the process of sectioning can include providing at least one opening agent to an opening formed in the sheet **111** after sectioning, wherein the opening agent is sufficient to maintain an opening in the sheet after sectioning. Some suitable methods of providing the opening agent can include depositing, coating, spraying, printing, rolling, transferring, and a combination thereof. In one particular embodiment, the mechanical object can be coated with a least one opening agent, wherein the opening agent can be transferred from a surface of the mechanical object to a surface of the sheet defining the opening. The opening agent can include a material selected from the group of



inorganic materials, organic materials, polymers, and a combination thereof. In one embodiment, the opening agent may be a foaming agent, surfactant, and a combination thereof.

Referring again to FIG. 1, after forming precursor shaped abrasive particles **123**, the particles may be translated through a post-forming zone **125**. Various processes may be conducted in the post-forming zone **125**, including for example, heating, curing, vibration, impregnation, doping, and a combination thereof.

In one embodiment, the post-forming zone **125** includes a heating process, wherein the precursor shaped abrasive particles **123** may be dried. Drying may include removal of a particular content of material, including volatiles, such as water. In accordance with an embodiment, the drying process can be conducted at a drying temperature of not greater than 300° C. such as not greater than 280° C. or even not greater than about 250° C. Still, in one non-limiting embodiment, the drying process may be conducted at a drying temperature of at least 50° C. It will be appreciated that the drying temperature may be within a range between any of the minimum and maximum temperatures noted above.

Furthermore, the precursor shaped abrasive particles **123** may be translated through a post-forming zone at a particular rate, such as at least about 0.2 feet/min and not greater than about 8 feet/min. Furthermore, the drying process may be conducted for a particular duration. For example, the drying process may be not greater than about six hours.

After the precursor shaped abrasive particles **123** are translated through the post-forming zone **125**, the particles may be removed from the belt **109**. The precursor shaped abrasive particles **123** may be collected in a bin **127** for further processing.

In accordance with an embodiment, the process of forming shaped abrasive particles may further comprise a sintering process. The sintering process can be conducted after collecting the precursor shaped abrasive particles **123** from the belt **109**. Sintering of the precursor shaped abrasive particles **123** may be utilized to densify the particles, which are generally in a green state. In a particular instance, the sintering process can facilitate the formation of a high-temperature phase of the ceramic material. For example, in one embodiment, the precursor shaped abrasive particles **123** may be sintered such that a high-temperature phase of alumina, such as alpha alumina is formed. In one instance, a shaped abrasive particle can comprise at least about 90 wt % alpha alumina for the total weight of the particle. In other instances, the content of alpha alumina may be greater, such that the shaped abrasive particle may consist essentially of alpha alumina.

The body of the shaped abrasive particles may include additives, such as dopants, which may be in the form of elements or compounds (e.g., oxides). Certain suitable additives can include alkali elements, alkaline earth elements, rare-earth elements, hafnium (Hf), zirconium (Zr), niobium (Nb), tantalum (Ta), molybdenum (Mo), and a combination thereof. In particular instances, the additive can include an element such as lithium (Li), sodium (Na), potassium (K), magnesium (Mg), calcium (Ca), strontium (Sr), barium (Ba), scandium (Sc), yttrium (Y), lanthanum (La), cesium (Ce), praseodymium (Pr), niobium (Nb), hafnium (Hf), zirconium (Zr), tantalum (Ta), molybdenum (Mo), vanadium (V), chromium (Cr), cobalt (Co), iron (Fe), germanium (Ge), manganese (Mn), nickel (Ni), titanium (Ti), zinc (Zn), and a combination thereof.

The body of a shaped abrasive article may include a specific content of additive (e.g., dopant). For example, the

body of a shaped abrasive particle may include not greater than about 12 wt % additive for the total weight of the body. In still other embodiments, they amount of additive may be less, such as not greater than about 11 wt %, not greater than about 10 wt %, not greater than about 9 wt %, not greater than about 8 wt %, not greater than about 7 wt %, not greater than about 6 wt %, or even not greater than about 5 wt %. Still, the amount of additive in at least one non-limiting embodiment can be at least about 0.5 wt %, such as at least about 1 wt %, at least about 1.3 wt %, at least about 1.8 wt %, at least about 2 wt %, at least about 2.3 wt %, at least about 2.8 wt %, or even at least about 3 wt %. It will be appreciated that the amount of additive within a body of a shaped abrasive particle may be within a range between any of the minimum and maximum percentages noted above.

While the process illustrated in the system **100** has described a shaping process conducted in a shaping zone **113** followed by a forming process at the forming zone **121**, and a post-forming process in a post-forming zone, other orders of the processes and zones are contemplated. For example, the process of shaping a surface of the sheet **111** can be conducted after a forming process. In still other instances, the forming process may be completed during the forming process, such that the forming process and shaping process are completed simultaneously. Moreover, while certain processes have been illustrated as being integral with a belt translation system, any of the processes described herein may be completed independent of each other and the belt translation system.

The shaped abrasive particles of the embodiments herein can have a body defined by a length (l), a width (w), and a height (h). The body can include a width (w) that is the longest dimension of the body and extending along a side of the particle. The body may further include a length (l) that can be a dimension extending through a portion of the body, such as the midpoint, or alternatively, may be a dimension extending between particular points on the outer surface of the body (e.g., between opposing corners). It will be appreciated that the body can have a variety of length dimensions depending upon the points of reference. Additionally, the shaped abrasive particle can further include a height (h), which may be a dimension of the shaped abrasive particle extending in a direction substantially perpendicular to the length and width in a direction defined by a side surface of the body **301**. Notably, as will be described in more detail herein, the body **301** can be defined by various heights depending upon the location on the body. In specific instances, the width can be greater than or equal to the length, the length can be greater than or equal to the height, and the width can be greater than or equal to the height.

Additionally, the body of a shaped abrasive particle of the embodiments herein can have various two-dimensional shapes. For example, the body can have a two-dimensional shape as viewed in a plane define by the length and width having a polygonal shape, ellipsoidal shape, a numeral, a Greek alphabet character, Latin alphabet character, Russian alphabet character, complex shapes utilizing a combination of polygonal shapes and a combination thereof. Particular polygonal shapes include triangular, rectangular, quadrilateral, pentagon, hexagon, heptagon, octagon, nonagon, decagon, any combination thereof.

FIG. 5 includes a perspective view illustration of a shaped abrasive particle in accordance with an embodiment. As illustrated, the shaped abrasive particle can have a corner-truncated triangular shape. In particular, the body **501** of the shaped abrasive particle can have a width (w) extending along a side surface of the body **501**, a length extending



through a midpoint **502** of the body **501**, and a height (h). In accordance with an embodiment, the body **501** can have a primary aspect ratio defined as a ratio of width:length. In certain instances, the primary aspect ratio of the body **501** can be at least about 1.2:1, such as at least about 1.5:1, at least about 2:1, at least about 3:1, or even at least about 4:1. Still, the primary aspect ratio may be not greater than about 100:1. It will be appreciated that the primary aspect ratio of the body **501** may be within a range between any of the minimum and maximum ratios noted above. The dimensions used to calculate the primary aspect ratio may be based upon a median value of a batch of shaped abrasive particles. For example, the length can be based upon a median profile length for a batch of shaped abrasive particles.

Furthermore, the body **501** can have a secondary aspect ratio defined by a ratio of width:height. In certain instances, the secondary aspect ratio of the body **501** may be at least about 1.2:1, such as at least about 1.5:1, at least about 2:1, at least about 3:1, at least about 4:1, at least about 5:1, or even at least about 10:1. Still, in at least one non-limiting embodiment, the body **501** can have a secondary aspect ratio that is not greater than about 100:1. It will be appreciated that the secondary aspect ratio may be within a range between any of the minimum and maximum ratios provided above. The dimensions used to calculate the secondary aspect ratio may be based upon a median value of a batch of shaped abrasive particles. For example, the height can be based upon a median interior height for a batch of shaped abrasive particles.

Furthermore, the shaped abrasive particles of the embodiments herein can have a tertiary aspect ratio defined by a ratio of the length:height. In certain instances, the tertiary aspect ratio of the body **501** may be at least about 1.2:1, such as at least about 1.5:1, at least about 2:1, at least about 3:1, at least about 4:1, at least about 5:1, or even at least about 10:1. Still, in at least one non-limiting embodiment, the body **501** can have a tertiary aspect ratio that is not greater than about 100:1. It will be appreciated that the tertiary aspect ratio may be within a range between any of the minimum and maximum ratios provided above. The dimensions used to calculate the tertiary aspect ratio may be based upon a median value of a batch of shaped abrasive particles. For example, the height can be based upon a median interior height for a batch of shaped abrasive particles.

FIG. 6 includes an illustration of a shaped abrasive particle formed in accordance with an embodiment. Notably, the body **601** can have a generally quadrilateral shape. However, in one particular embodiment, the body **601** may be a corner truncated quadrilateral, and more particularly a corner truncated parallelogram or trapezoidal shape.

FIG. 7A includes a perspective view illustration of a shaped abrasive particle in accordance with an embodiment. Notably, body **701** can have a first long side **702**, a second long side **703**, and a third long side **704**. Furthermore, the body **701** can include a first short side **705** coupled to the first long side **702** and second long side **703**. The body **701** may further include a second short side **706** coupled to the first long side **702** and third long side **704**. While the body **701** of the shaped abrasive particle may be considered to have a generally pentagon shape as viewed in a plane defined by the length and width, in particular instances, the body **701** can be defined as a corner truncated triangle, wherein the first short side **705** and second short side **706** define flat surfaces where otherwise a corner, such as corner **722**, would exist. Notably, such corner-truncated shapes may represent a significant portion of shaped abrasive particles in

a batch, formed through the process described herein, and which will be described in more detail herein.

As illustrated, the body **701** can have a first angle **707** defined between the first long side **702** and first short side **705** as viewed at the upper major surface **730** of the body **701**. In accordance with an embodiment, the first angle **707** can be greater than about 90°. In more particular instances, the first angle **707** can be at least about 92°, at least about 95°, at least about 100°, or even at least about 105°. Still, the first angle, in one non-limiting embodiment, can be not greater than about 160°.

The body can further include a second angle **708** formed between the first short side **705** and second long side **703** as viewed at the upper major surface **730** of the body **701**. In accordance with an embodiment, the second angle **708** can be the same as the first angle **707**. Still, in another embodiment, the second angle **708** can be different than the first angle **707**. According to one instance, the second angle **708** can be obtuse. Alternatively, the second angle **708** may be greater than about 90°, and more particularly, at least about 92°, at least about 95°, at least about 100°, or even at least about 105°. Still, the second angle **708**, in one non-limiting embodiment, can be not greater than about 160°.

As further illustrated, the body **701** of the shaped abrasive particle can include a third angle **709** defined as the angle between the second short side **706** and first long side **702** as viewed at the upper major surface **730** of the body **701**. The third angle **709** may be the same as the first angle **707** or the second angle **708**. Alternatively, the third angle **709** may be different than the first angle **707** and second angle **708**.

The body **701** can also include a fourth angle **710** defined as the angle between the second short surface **706** and third long surface **704**. The fourth angle **710** may be different than the first angle **707**, second angle **708**, or third angle **709**. In particular instances, the fourth angle **710** can be less than the first angle **707**, less than the second angle **708**, or less than the third angle **709**. In at least one particular embodiment, the fourth angle **710** may be substantially orthogonal (90°). In yet other instances, the fourth angle **710** may be greater than 90°.

The body **701** may further include a fifth angle **711** between the third long side **704** and second long side **703** as viewed top down looking at the upper major surface **730** of the body **701**. Notably, the fifth angle **711** can be different than the first angle **707**, the second angle **708**, the third angle **709**, or the fourth angle **710**. In particular instances, the fifth angle **711** can be less than the first angle **707**, less than the second angle **708**, less than the third angle **709**, or even less than the fourth angle **710**. The fifth angle **711** can define the corner **722** of a triangle, and thus be less than about 90°, and more particularly less than about 70°. While the body **710** has been illustrated as having a first short side and a second short side **706**, it will be appreciated that the body could incorporate a third short side separating the second long side and third long side **704**.

In accordance with an embodiment, the first short side **705** can have a width **781** that is not greater than about 60% of a width of the first long side **702**. In other embodiments, the width of the first short side **705** relative to the first long side **702** can be less, such as not greater than about 50%, or not greater than about 40%, not greater than about 30%, not greater than about 28%, or even not greater than about 25%. Still, the short side **705** can be at least about 2%, such as at least about 5%, at least about 10%, at least about 15%, or even at least about 20% of the width of the first long side **702**. It will be appreciated that the width of the first short



side **705** can be within a range between any of the minimum and maximum percentages noted above.

Moreover, the percentages noted above with respect to the width **781** of the first short side **705** relative to the width of longest side of the particle can be representative of median values for a batch. For example, a batch of shaped abrasive particles may include a content of corner-truncated shapes. The width of the corner-truncated portions can have a median value for the batch. The particles of the batch can also have a median width represented by the median dimension of the longest side of the particles of the batch, or at least the median dimension of the longest side of the particles from a representative sample of the batch. The batch can have a median corner-truncated width of not greater than about 50%, such as not greater than about 40%, not greater than about 30%, not greater than about 28%, or even not greater than about 25% of the median width of the particles of the batch. Still, the batch can include corner-truncated shapes, wherein the median width of the truncated corners can be at least about 2%, such as at least about 5%, at least about 10%, at least about 15%, or even at least about 20% of the median width of the particles. It will be appreciated that the median width of the truncated corners for particles of a batch can be within a range between any of the minimum and maximum percentages noted above.

Furthermore, it will be appreciated that the width of the second short side **706** can have the same characteristics of the first short side **705** relative to the first long side **702**. Additionally, the width of the second short side **706** may differ with respect to the width of the first short side **705**.

In accordance with an embodiment, the first long side **702** can have a width ( $w_1$ ) that is substantially equal to the width ( $w_2$ ) of the second long side **703**. Still, the width ( $w_1$ ) of the first long side **702** may be significantly different than the width ( $w_2$ ) of the second long side **703**. Moreover, the width ( $w_1$ ) of the first long side **702** may be substantially the same as the width ( $w_3$ ) of the third long side **704**. Alternatively, the width ( $w_1$ ) of the first long side **702** may be significantly different than the width ( $w_3$ ) of the third long side **704**. Additionally, the width ( $w_2$ ) of the second long side **703** may be substantially the same as the width ( $w_3$ ) of the third long side **704**. Alternatively, the width ( $w_2$ ) of the second long side **703** may be significantly different than the width ( $w_3$ ) of the third long side **704**.

FIG. 7B includes a cross-sectional illustration of a portion of the shaped abrasive particle of FIG. 7A. Notably, the cross-sectional illustration is taken through the axis **750** which is defined by a point at one corner **721** of the body **701** and a midpoint **741** of the body **701**. In accordance with a particular embodiment, the body **701** can have a greater height at a midpoint **741** of the shaped abrasive particle as compared to the height of the body measured at the corner **721**. In certain instances, the shaped abrasive particles can have a corner/midpoint differential height of at least 1.1, wherein the corner/midpoint differential height ( $c/m\Delta h$ ) is a measure of the height of at least one corner of the body divided by the height at the midpoint. In certain embodiments, the corner/midpoint differential height can be greater, such as at least about 1.2, at least about 1.4, wherein the at least about 1.6, at least about 1.8, at least about 2, at least about 2.2, at least about 2.4, at least about 3, or even at least about 4. Still, in one non-limiting embodiment, the corner/midpoint differential height ( $c/m\Delta h$ ) can be not greater than about 20, such as not greater than about 18, not greater than about 15, not greater than about 12, not greater than about 10, not greater than about 8, not greater than about 6, or even not greater than about 4. It will be appreciated that the

shaped abrasive particles herein can have a body having a corner/midpoint differential height ( $c/m\Delta h$ ) within a range between any of the minimum and maximum values noted above.

Still, it will be appreciated that the foregoing is an example, and in other instances, the corner height of the body can be greater than the midpoint height. In particular instances, the body can have a midpoint/corner differential height within a range of any of the minimum and maximum values noted above for the corner/midpoint differential height.

FIG. 7C includes a cross-sectional illustration of a portion of the shaped abrasive particle of FIG. 7A. In particular, FIG. 7C includes a cross-sectional illustration of the shaped abrasive particle along axis **760**, which is defined as an axis extending through the midpoint **741** and a midpoint **742** of a side **703** of the body **701**. In accordance with one embodiment, the body **701** can have a greater height at a midpoint **741** of the body **701** than a height at a midpoint edge **742** of the body **701**. Notably, the shaped abrasive particles can have an edge/midpoint differential height ( $e/m\Delta t$ ) of at least 1.1, wherein the edge/midpoint differential height is a measure of the height of the body on an edge of the side surface at the midpoint between two corners divided by the height of at the midpoint. In other embodiments, the edge/midpoint differential height ( $e/m\Delta t$ ) can be greater, such as at least about 1.2, at least about 1.4, wherein the at least about 1.6, at least about 1.8, at least about 2, at least about 2.2, at least about 2.4, at least about 3, or even at least about 4. Still, in one non-limiting embodiment, the edge/midpoint differential height ( $e/m\Delta t$ ) can be not greater than about 20, such as not greater than about 18, not greater than about 15, not greater than about 12, not greater than about 10, not greater than about 8, not greater than about 6, or even not greater than about 4. It will be appreciated that the shaped abrasive particles herein can have a body having an edge/midpoint differential height ( $e/m\Delta t$ ) within a range between any of the minimum and maximum values noted above.

Still, it will be appreciated that the foregoing is an example, and in other instances, the edge height of the body can be greater than the midpoint height. In particular instances, the body can have a midpoint/edge differential height within a range of any of the minimum and maximum values noted above for the edge/midpoint differential height.

FIG. 8 includes a cross-sectional illustration of a portion of a shaped abrasive particle in accordance with an embodiment. Notably, the shaped abrasive particle can include a body **801** having a bottom surface **804**, an upper major surface **802** opposite the bottom surface **804**, and a side surface **803** joining the bottom surface **804** and upper major surface **802**. As further illustrated, the body **801** can include a side surface **805** opposite the side surface **803** joining the bottom surface **804** and upper major surface **802**. In accordance with a particular embodiment, as illustrated in FIG. 8, the body **801** can have a curved or linear upper major surface **802**. Notably, in some instances, the upper major surface **802** can have a convex contour such that the height of the body **801** at the midpoint ( $t_m$ ) is greater than the height at either one of the side surfaces ( $t_s$ ) **803** or **805**. For some embodiments, the bottom surface **802** may be substantially planer as compared to the upper major surface **802**.

FIG. 9 includes a cross-sectional illustration of an alternative shaped abrasive particle in accordance with an embodiment. Notably, the shaped abrasive particle can have a body **901** including a bottom surface **904**, an upper major surface **902** opposite the bottom surface **904**, and side surfaces **903** and **905** opposite each other and joining the



bottom surface **905** and upper major surface **902**. As illustrated, the body **901** can have a particularly unique contour, wherein the upper major surface **902** has a convex contour, and the bottom surface **904** also has a convex contour such that the height at the midpoint ( $t_m$ ) is significantly greater than the height of the body **901** at the edges ( $t_e$ ) defined by surfaces **901** and **905**.

The shaped abrasive particles of embodiments herein can have a particular size, as measured by the width of the body. For example, the shaped abrasive particles may have a median particle size of not greater than about 5 mm. Alternatively, the median particle may be less, such as not greater than about 4 mm, not greater than about 3 mm, not greater than about 2 mm, or even not greater than about 1.5 mm. In still another aspect, the median particle size of the shaped abrasive particles can be at least about 10 microns, at least about 100 microns, at least about 200 microns, at least about 400 microns, at least about 600 microns, or even at least about 800 microns. It will be appreciated that the median particle size of the shaped abrasive particles can be within a range between any of the above minimum and maximum values.

The shaped abrasive particles of embodiments herein can have a particular grain size, which can be a measure of crystalline grain size within the particle, particularly for grains of alpha alumina. For example, the shaped abrasive particles may have an average grain size of not greater than about 500 microns, such as not greater than about 250 microns, or even not greater than about 100 microns, not greater than about 50 microns, not greater than about 20 microns, or even not greater than about 1 micron. In another aspect, the average grain size can be at least about 0.01 microns, such as at least about 0.05 microns, at least about 0.08 microns, or even at least about 0.1 microns. It will be appreciated that the average grain size of the shaped abrasive particles can be within a range between any of the above minimum and maximum values.

FIG. 10 includes an illustration of a shaped abrasive particle according to another embodiment. As depicted, the shaped abrasive particle **1000** may include a body **1001** that may be formed according to an embodiment herein. Notably, the shaped abrasive particle may be formed from an extruded sheet via a punching process. The body **1001** can include a central portion **1002** that extends along a longitudinal axis **1004**. A first radial arm **1006** may extend outwardly from the central portion **1002** along the length of the central portion **1002**. A second radial arm **1008** may extend outwardly from the central portion **1002** along the length of the central portion **1002**. A third radial arm **1010** may extend outwardly from the central portion **1002** along the length of the central portion **1002**. Moreover, a fourth radial arm **1012** may extend outwardly from the central portion **1002** along the length of the central portion **1002**. The radial arms **1006**, **1008**, **1010**, **1012** may be equally spaced around the central portion **1002** of the shaped abrasive particle **1000**.

As shown in FIG. 10, the first radial arm **1006** may include a generally arrow shaped distal end **1020**. The second radial arm **1008** may include a generally arrow shaped distal end **1022**. The third radial arm **1010** may include a generally arrow shaped distal end **1024**. Further, the fourth radial arm **1012** may include a generally arrow shaped distal end **1026**.

FIG. 10 also illustrates that the shaped abrasive particle **1000** may be formed with a first void **1030** between the first radial arm **1006** and the second radial arm **1008**. A second void **1032** may be formed between the second radial arm

**1008** and the third radial arm **1010**. A third void **1034** may also be formed between the third radial arm **1010** and the fourth radial arm **1012**. Additionally, a fourth void **1036** may be formed between the fourth radial arm **1012** and the first radial arm **1006**.

FIGS. 11 and 12 include an illustration of a shaped abrasive particle according to another embodiment. As shown, the shaped abrasive particle **1100** may include a body **1101** that has a generally cube-like shape. It will be appreciated that the shaped abrasive particle may be formed to have other polyhedral shapes. The body **1101** may have a first end face **1102** and a second end face **1104**, a first lateral face **1106** extending between the first end face **1102** and the second end face **1104**, a second lateral face **1108** extending between the first end face **1102** and the second end face **1104**. Further, the body **1101** can have a third lateral face **1110** extending between the first end face **1102** and the second end face **1104**, and a fourth lateral face **1112** extending between the first end face **1102** and the second end face **1104**.

As shown, the first end face **1102** and the second end face **1104** can be parallel to each other and separated by the lateral faces **1106**, **1108**, **1110**, and **1112**, giving the body a cube-like structure. However, in a particular aspect, the first end face **1102** can be rotated with respect to the second end face **1104** to establish a twist angle **1114**. In particular instances, the shaped abrasive particle **1100** can be formed from the processes described herein, including sectioning a sheet, and more particularly sectioning a sheet that has been torqued or twisted in a particular manner to impart a twist angle to the finally-formed shaped abrasive particle. In certain instances, the twist of the body **1101** can be along one or more axes and define particular types of twist angles. For example, as illustrated in a top-down view of the body in FIG. 12 looking down the longitudinal axis **1180** defining a length of the body **1101** on the end face **1102** parallel to a plane defined by the lateral axis **1181** extending along a dimension of width of the body **1101** and the vertical axis **1182** extending along a dimension of height of the body **1101**. According to one embodiment, the body **1101** can have a longitudinal twist angle **1114** defining a twist in the body **1101** about the longitudinal axis such that the end faces **1102** and **1104** are rotated relative to each other. The twist angle **1114**, as illustrated in FIG. 12 can be measured as the angle between a tangent of a first edge **1122** and a second edge **1124**, wherein the first edge **1122** and second edge **1124** are joined by and share a common edge **1126** extending longitudinally between two of the lateral faces (**1110** and **1112**). It will be appreciated that other shaped abrasive particles can be formed to have twist angles relative to the lateral axis, the vertical axis, and a combination thereof. Any such twist angles can have a value as described in the embodiments herein.

In a particular aspect, the twist angle **1114** can be at least about  $1^\circ$ . In other instances, the twist angle **1114** can be greater, such as at least about  $2^\circ$ , at least about  $5^\circ$ , at least about  $8^\circ$ , at least about  $10^\circ$ , at least about  $12^\circ$ , at least about  $15^\circ$ , at least about  $18^\circ$ , at least about  $20^\circ$ , at least about  $25^\circ$ , at least about  $30^\circ$ , at least about  $40^\circ$ , at least about  $50^\circ$ , at least about  $60^\circ$ , at least about  $70^\circ$ , at least about  $80^\circ$ , or even at least about  $90^\circ$ . Still, according to certain embodiments, the twist angle **1114** can be not greater than about  $360^\circ$ , such as not greater than about  $330^\circ$ , such as not greater than about  $300^\circ$ , not greater than about  $270^\circ$ , not greater than about  $230^\circ$ , not greater than about  $200^\circ$ , or even not greater than about  $180^\circ$ . It will be appreciated that certain shaped abra-



sive particles can have a twist angle within a range between any of the minimum and maximum angles noted above.

FIG. 13 includes an illustration of a shaped abrasive particle according to an embodiment. The shaped abrasive grain 1300 may include a body 1301 including a base surface 1302 and an upper surface 1304 separated from each other by one or more side surfaces 1310, 1312, and 1314. According to one particular embodiment, the body 1301 can be formed such that the base surface 1302 has a planar shape different than a planar shape of the upper surface 1304, wherein the planar shape is viewed in the plane defined by the respective surface. For example, as illustrated in the embodiment of FIG. 13, the body 1301 can have base surface 1302 generally have a circular shape and an upper surface 1304 having a generally triangular shape. It will be appreciated that other variations are feasible, including any combination of shapes at the base surface 1302 and upper surface 1304.

FIG. 14 includes a cross-sectional illustration of a coated abrasive article incorporating the abrasive particulate material in accordance with an embodiment. As illustrated, the coated abrasive 1400 can include a substrate 1401 and a make coat 1403 overlying a surface of the substrate 1401. The coated abrasive 1400 can further include a first type of abrasive particulate material 1405 in the form of a first type of shaped abrasive particle, a second type of abrasive particulate material 1406 in the form of a second type of shaped abrasive particle, and a third type of abrasive particulate material in the form of diluent abrasive particles, which may not necessarily be shaped abrasive particles, and having a random shape. The coated abrasive 1400 may further include size coat 1404 overlying and bonded to the abrasive particulate materials 1405, 1406, 1407, and the make coat 1404.

According to one embodiment, the substrate 1401 can include an organic material, inorganic material, and a combination thereof. In certain instances, the substrate 1401 can include a woven material. However, the substrate 1401 may be made of a non-woven material. Particularly suitable substrate materials can include organic materials, including polymers, and particularly, polyester, polyurethane, polypropylene, polyimides such as KAPTON from DuPont, paper. Some suitable inorganic materials can include metals, metal alloys, and particularly, foils of copper, aluminum, steel, and a combination thereof.

The make coat 1403 can be applied to the surface of the substrate 1401 in a single process, or alternatively, the abrasive particulate materials 1405, 1406, 1407 can be combined with a make coat 1403 material and applied as a mixture to the surface of the substrate 1401. Suitable materials of the make coat 1403 can include organic materials, particularly polymeric materials, including for example, polyesters, epoxy resins, polyurethanes, polyamides, polyacrylates, polymethacrylates, poly vinyl chlorides, polyethylene, polysiloxane, silicones, cellulose acetates, nitrocellulose, natural rubber, starch, shellac, and mixtures thereof. In one embodiment, the make coat 1403 can include a polyester resin. The coated substrate can then be heated in order to cure the resin and the abrasive particulate material to the substrate. In general, the coated substrate 1401 can be heated to a temperature of between about 100° C. to less than about 250° C. during this curing process.

The abrasive particulate materials 1405, 1406, and 1407 can include different types of shaped abrasive particles according to embodiments herein. The different types of shaped abrasive particles can differ from each other in composition, two-dimensional shape, three-dimensional

shape, size, and a combination thereof as described in the embodiments herein. As illustrated, the coated abrasive 1400 can include a first type of shaped abrasive particle 1405 having a generally triangular two-dimensional shape and a second type of shaped abrasive particle 1406 having a quadrilateral two-dimensional shape. The coated abrasive 1400 can include different amounts of the first type and second type of shaped abrasive particles 1405 and 1406. It will be appreciated that the coated abrasive may not necessarily include different types of shaped abrasive particles, and can consist essentially of a single type of shaped abrasive particle.

The abrasive particles 1407 can be diluent particles different than the first and second types of shaped abrasive particles 1405 and 1406. For example, the diluent particles can differ from the first and second types of shaped abrasive particles 1405 and 1406 in composition, two-dimensional shape, three-dimensional shape, size, and a combination thereof. For example, the abrasive particles 1407 can represent conventional, crushed abrasive grit having random shapes. The abrasive particles 1407 may have a median particle size less than the median particle size of the first and second types of shaped abrasive particles 1405 and 1406.

After sufficiently forming the make coat 1403 with the abrasive particulate materials 1405, 1406, 1407 contained therein, the size coat 1404 can be formed to overlie and bond the abrasive particulate material 1405 in place. The size coat 1404 can include an organic material, may be made essentially of a polymeric material, and notably, can use polyesters, epoxy resins, polyurethanes, polyamides, polyacrylates, polymethacrylates, poly vinyl chlorides, polyethylene, polysiloxane, silicones, cellulose acetates, nitrocellulose, natural rubber, starch, shellac, and mixtures thereof.

FIG. 15 includes an illustration of a bonded abrasive article incorporating the abrasive particulate material in accordance with an embodiment. As illustrated, the bonded abrasive 1500 can include a bond material 1501, abrasive particulate material 1502 contained in the bond material, and porosity 1508 within the bond material 1501. In particular instances, the bond material 1501 can include an organic material, inorganic material, and a combination thereof. Suitable organic materials can include polymers, such as epoxies, resins, thermosets, thermoplastics, polyimides, polyamides, and a combination thereof. Certain suitable inorganic materials can include metals, metal alloys, vitreous phase materials, crystalline phase materials, ceramics, and a combination thereof.

The abrasive particulate material 1502 of the bonded abrasive 1500 can include different types of shaped abrasive particles 1503, 1504, 1505, and 1506, which can have any of the features of different types of shaped abrasive particles as described in the embodiments herein. Notably, the different types of shaped abrasive particles 1503, 1504, 1505, and 1506 can differ from each other in composition, two-dimensional shape, three-dimensional shape, size, and a combination thereof as described in the embodiments herein.

The bonded abrasive 1500 can include a type of abrasive particulate material 1507 representing diluent abrasive particles, which can differ from the different types of shaped abrasive particles 1503, 1504, 1505, and 1506 in composition, two-dimensional shape, three-dimensional shape, size, and a combination thereof.

The porosity 1508 of the bonded abrasive 1500 can be open porosity, closed porosity, and a combination thereof. The porosity 1508 may be present in a majority amount (vol %) based on the total volume of the body of the bonded abrasive 1500. Alternatively, the porosity 1508 can be



present in a minor amount (vol %) based on the total volume of the body of the bonded abrasive **1500**. The bond material **1501** may be present in a majority amount (vol %) based on the total volume of the body of the bonded abrasive **1500**. Alternatively, the bond material **1501** can be present in a minor amount (vol %) based on the total volume of the body of the bonded abrasive **1500**. Additionally, abrasive particulate material **1502** can be present in a majority amount (vol %) based on the total volume of the body of the bonded abrasive **1500**. Alternatively, the abrasive particulate material **1502** can be present in a minor amount (vol %) based on the total volume of the body of the bonded abrasive **1500**.

FIG. **16A** includes a perspective view illustration of an abrasive particle in accordance with an embodiment. Additionally, FIG. **16B** includes a cross-sectional illustration of the abrasive particle of FIG. **16A**. The body **1601** includes an upper surface **1603** a bottom major surface **1604** opposite the upper surface **1603**. The upper surface **1603** and the bottom surface **1604** can be separated from each other by side surfaces **1605**, **1606**, and **1607**. As illustrated, the body **1601** of the shaped abrasive particle **1600** can have a generally triangular shape as viewed in a plane of the upper surface **1603**. In particular, the body **1601** can have a length ( $L_{middle}$ ) as shown in FIG. **16B**, which may be measured at the bottom surface **1604** of the body **1601** and extending from a corner **1613** through a midpoint **1681** of the body **1601** to a midpoint at the opposite edge **1614** of the body. Alternatively, the body can be defined by a second length or profile length ( $L_p$ ), which is the measure of the dimension of the body from a side view at the upper surface **1603** from a first corner **1613** to an adjacent corner **1612**. Notably, the dimension of  $L_{middle}$  can be a length defining a distance between a height at a corner ( $h_c$ ) and a height at a midpoint edge ( $h_m$ ) opposite the corner. The dimension  $L_p$  can be a profile length along a side of the particle defining the distance between  $h_1$  and  $h_2$ . Reference herein to the length can be reference to at least one of  $L_{middle}$  or  $L_p$ .

It will be appreciated that the above characteristics can be attributed to a batch of shaped abrasive particles, which may be a group of shaped abrasive particles made through the same forming process. In another instance, a batch of shaped abrasive particles can be a group of shaped abrasive particles made by the same forming process and under substantially the same conditions using the same forming process. In yet another instance, a batch of shaped abrasive particles can be a group of shaped abrasive particles of an abrasive article, such as a fixed abrasive article, and more particularly a coated abrasive article, which may be independent of a particular forming method.

Moreover, reference herein to any dimensional characteristic (e.g.,  $h_1$ ,  $h_2$ ,  $h_i$ ,  $w$ ,  $L_{middle}$ ,  $L_p$ , and the like) can be reference to a dimension of a single particle, a median value, or an average value derived from analysis of a suitable sampling of particles from a batch. Unless stated explicitly, reference herein to a dimensional characteristic can be considered reference to a median value that is based on a statistically significant value derived from a random sampling of suitable number of particles of a batch. Notably, for certain embodiments herein, the sample size can include at least 10, and more typically, at least 40 randomly selected particles from a batch of particles. A batch of particles may include, but need not necessarily be limited to, a group of particles that are collected from a single process run. In yet another instance, a batch of shaped abrasive particles can be a group of shaped abrasive particles of an abrasive article, such as a fixed abrasive article, and more particularly, a coated abrasive article, which may be independent of a

particular forming method, but having one or more defining features present in a particular population of the particles. For example, a batch of particles may include an amount of shaped abrasive particles suitable for forming a commercial grade abrasive product, such as at least about 20 lbs. of particles.

In accordance with an embodiment, the body **1601** of the shaped abrasive particle can have a first corner height ( $h_c$ ) at a first region of the body defined by a corner **1613**. Notably, the corner **1613** may be the point of greatest height on the body **1601**. However, in other instances, the height at the corner **1613** does not necessarily represent the point of greatest height on the body **1601**. The corner **1613** can be defined as a point or region on the body **1601** defined by the joining of the upper surface **1603** and two side surfaces **1605** and **1607**. The body **1601** may further include other corners, spaced apart from each other, including for example, corner **1611** and corner **1612**. As further illustrated, the body **1601** can include edges **1614**, **1615**, and **1616** that can be separated from each other by the corners **1611**, **1612**, and **1613**. The edge **1614** can be defined by an intersection of the upper surface **1603** with the side surface **1606**. The edge **1615** can be defined by an intersection of the upper surface **1603** and side surface **1605** between corners **1611** and **1613**. The edge **1616** can be defined by an intersection of the upper surface **1603** and side surface **1607** between corners **1612** and **1613**.

As further illustrated, the body **1601** can include a second midpoint height ( $h_m$ ) at a second end of the body, which can be defined by a region at the midpoint of the edge **1614**, which can be opposite the first end defined by the corner **1613**. The axis **1650** can extend between the two ends of the body **1601**. FIG. **16B** is a cross-sectional illustration of the body **1601** along the axis **1650**, which can extend through a midpoint **1681** of the body along the dimension of length ( $L_{middle}$ ) between the corner **1613** and the midpoint of the edge **1614**.

In certain instances, the body of the shaped abrasive particle may have alternative features as compared to certain features described herein. For example, in one embodiment, the body can have an interior height that is less than the height of the body at the corners. In one particular embodiment, the body can have an average difference in height of at least about 5 microns, such as at least about 10 microns, or even at least about 20 microns. The average difference in height can be the absolute value of  $[h_c - h_m]$  between a first corner height ( $h_c$ ) and a second midpoint height ( $h_m$ ). It will be appreciated that average difference in height may be calculated as  $h_m - h_c$  when the height of the body **301** at a midpoint of the edge is greater than the height at an opposite corner. In other instances, the average difference in height  $[h_c - h_m]$ , can be at least about 25 microns, at least about 60 microns, or even at least about 100 microns. In one non-limiting embodiment, the average difference in height can be not greater than about 300 microns, not greater than about 180 microns, or even not greater than about 80 microns. It will be appreciated that the average difference in height can be within a range between any of the minimum and maximum values noted above.

Moreover, the average difference in height can be based upon an average value of  $h_c$ . For example, the average height of the body at the corners ( $A_{h_c}$ ) can be calculated by measuring the height of the body at all corners and averaging the values, and may be distinct from a single value of height at one corner ( $h_c$ ). Accordingly, the average difference in height may be calculated as the absolute value of the equation  $[A_{h_c} - h_i]$ . Furthermore, it will be appreciated that the average difference in height can be calculated using a



median interior height (Mhi) calculated from a suitable sample size from a batch of shaped abrasive particles and an average height at the corners for all particles in the sample size. Accordingly, the average difference in height may be given by the absolute value of the equation  $[Ahc - Mhi]$ . The heights  $hc$  and  $hm$  of the particles can be measured using a STIL (Sciences et Techniques Industrielles de la Lumière—France) Micro Measure 3D Surface Profilometer (white light (LED) chromatic aberration technique) and the average difference in height can be calculated based on the average values of  $hc$  and  $hm$  from the sample.

In one instance, the body can have an interior height ( $hi$ ), which can be the smallest dimension of height of the body as measured along a dimension between any corner and opposite midpoint edge on the body. In particular instances wherein the body is a generally triangular (or truncated triangular) two-dimensional shape, the interior height ( $hi$ ) may be the smallest dimension of height (i.e., measure between the bottom surface **1604** and the upper surface **1603**) of the body for three measurements taken between each of the three corners and the opposite midpoint edges. The interior height ( $hi$ ) of the body of a shaped abrasive particle is illustrated in FIG. **16B**. According to one embodiment, the interior height ( $hi$ ) can be at least about 28% of the width ( $w$ ). The height ( $hi$ ) of any particle may be measured by sectioning or mounting and grinding the shaped abrasive particle and viewing in a manner sufficient (e.g., light microscope or SEM) to determine the smallest height ( $hi$ ) within the interior of the body **301**. In one particular embodiment, the height ( $hi$ ) can be at least about 29% of the width, such as at least about 30%, or even at least about 33% of the width of the body. For one non-limiting embodiment, the height ( $hi$ ) of the body can be not greater than about 80% of the width, such as not greater than about 76%, not greater than about 73%, not greater than about 70%, not greater than about 68% of the width, not greater than about 56% of the width, not greater than about 48% of the width, or even not greater than about 40% of the width. It will be appreciated that the height ( $hi$ ) of the body can be within a range between any of the above noted minimum and maximum percentages.

A batch of shaped abrasive particles, can be fabricated, wherein the median interior height value (Mhi) can be controlled, which may facilitate improved performance. In particular, the median internal height ( $hi$ ) of a batch can be related to a median width of the shaped abrasive particles of the batch in the same manner as described above. Notably, the median interior height (Mhi) can be at least about 20%, such as at least about 22%, at least about 24%, or even at least about 26% of the median width of the shaped abrasive particles of the batch. For one non-limiting embodiment, the median interior height (Mhi) of the body can be not greater than about 80%, such as not greater than about 76%, not greater than about 70%, not greater than about 60%, not greater than about 50%, not greater than about 40%, not greater than about 38%, or even not greater than about 35% of the median width. It will be appreciated that the median interior height (Mhi) of the body can be within a range between any of the above noted minimum and maximum percentages.

Furthermore, the batch of shaped abrasive particles may exhibit improved dimensional uniformity as measured by the standard deviation of a dimensional characteristic from a suitable sample size. According to one embodiment, the shaped abrasive particles can have an interior height variation ( $Vhi$ ), which can be calculated as the standard deviation of interior height ( $hi$ ) for a suitable sample size of particles

from a batch. The interior height variation can be not greater than about 60 microns, such as not greater than about 58 microns, not greater than about 56 microns, or even not greater than about 54 microns. In one non-limiting embodiment, the interior height variation ( $Vhi$ ) can be at least about 2 microns. It will be appreciated that the interior height variation of the body can be within a range between any of the above noted minimum and maximum values.

For another embodiment, the body of the shaped abrasive particle can have an interior height ( $hi$ ) of at least about 100 microns, such as at least about 200 microns. More particularly, the height may be at least about 250 microns, such as at least about 300 microns, or even at least about 400 microns. In still one non-limiting embodiment, the height of the body can be not greater than about 8 mm, such as not greater than about 5 mm, not greater than about 4 mm, not greater than about 3 mm, such as not greater than about 2 mm, not greater than about 1.5 mm, not greater than about 1 mm, not greater than about 800 microns, not greater than about 600 microns, or even not greater than about 400 microns. It will be appreciated that the height of the body can be within a range between any of the above noted minimum and maximum values. Moreover, it will be appreciated that the above range of values can be representative of a median interior height (Mhi) value for a batch of shaped abrasive particles.

For certain embodiments herein, the body of the shaped abrasive particle can have particular dimensions, including for example, a width  $\geq$  length, a length  $\geq$  height, and a width  $\geq$  height, and even more particularly, a width  $>$  length, a length  $>$  height, and a width  $>$  height. The body of the shaped abrasive particle can have a width ( $w$ ) of at least about 600 microns, such as at least about 700 microns, at least about 800 microns, or even at least about 900 microns. In one non-limiting instance, the body can have a width of not greater than about 4 mm, such as not greater than about 3 mm, not greater than about 2.5 mm, or even not greater than about 2 mm. It will be appreciated that the width of the body can be within a range between any of the above noted minimum and maximum values. Moreover, it will be appreciated that the above range of values can be representative of a median width (Mw) for a batch of shaped abrasive particles.

The body of the shaped abrasive particle can have particular dimensions, including for example, a length ( $L$  middle or  $Lp$ ) of at least about 0.4 mm, such as at least about 0.6 mm, at least about 0.8 mm, or even at least about 0.9 mm. Still, for at least one non-limiting embodiment, the body can have a length of not greater than about 4 mm, such as not greater than about 3 mm, not greater than about 2.5 mm, or even not greater than about 2 mm. It will be appreciated that the length of the body can be within a range between any of the above noted minimum and maximum values. Moreover, it will be appreciated that the above range of values can be representative of a median length (ML), which may be more particularly, a median middle length (MLmiddle) or median profile length (MLp) for a batch of shaped abrasive particles.

The shaped abrasive particle can have a body having a particular amount of dishing, wherein the dishing value ( $d$ ) can be defined as a ratio between an average height of the body at the corners ( $Ahc$ ) as compared to smallest dimension of height of the body at the interior ( $hi$ ). The average height of the body at the corners ( $Ahc$ ) can be calculated by measuring the height of the body at all corners and averaging the values, and may be distinct from a single value of height at one corner ( $hc$ ). The average height of the body at the



corners or at the interior can be measured using a STIL (Sciences et Techniques Industrielles de la Lumiere—France) Micro Measure 3D Surface Profilometer (white light (LED) chromatic aberration technique). Alternatively, the dishing may be based upon a median height of the particles at the corner (Mhc) calculated from a suitable sampling of particles from a batch. Likewise, the interior height (hi) can be a median interior height (Mhi) derived from a suitable sampling of shaped abrasive particles from a batch. According to one embodiment, the dishing value (d) can be not greater than about 2, such as not greater than about 1.9, not greater than about 1.8, not greater than about 1.7, not greater than about 1.6, not greater than about 1.5, not greater than about 1.3, not greater than about 1.2, not greater than about 1.14, or even not greater than about 1.10. Still, in at least one non-limiting embodiment, the dishing value (d) can be at least about 0.9, such as at least about 1.0, or even at least about 1.01. It will be appreciated that the dishing ratio can be within a range between any of the minimum and maximum values noted above. Moreover, it will be appreciated that the above dishing values can be representative of a median dishing value (Md) for a batch of shaped abrasive particles.

The shaped abrasive particles of the embodiments herein, including for example, the body **1601** of the particle of FIG. **16A** can have a bottom surface **1604** defining a bottom area (Ab). In particular instances the bottom surface **1604** can be the largest surface of the body **1601**. The bottom surface can have a surface area defined as the bottom area (Ab) that is greater than the surface area of the upper surface **1603**. Additionally, the body **1601** can have a cross-sectional midpoint area (Am) defining an area of a plane perpendicular to the bottom area and extending through a midpoint **1681** of the particle. In certain instances, the body **1601** can have an area ratio of bottom area to midpoint area (Ab/Am) of not greater than about 6. In more particular instances, the area ratio can be not greater than about 5.5, such as not greater than about 5, not greater than about 4.5, not greater than about 4, not greater than about 3.5, or even not greater than about 3. Still, in one non-limiting embodiment, the area ratio may be at least about 1.1, such as at least about 1.3, or even at least about 1.8. It will be appreciated that the area ratio can be within a range between any of the minimum and maximum values noted above. Moreover, it will be appreciated that the above area ratios can be representative of a median area ratio for a batch of shaped abrasive particles.

The shaped abrasive particles of the embodiments herein can have a percent flashing that may facilitate improved performance. Notably, the flashing can define an area of the particle as viewed along one side, such as illustrated in FIG. **16C**, wherein the flashing extends from a side surface of the body within the boxes **1642** and **1643**. The flashing can represent tapered regions proximate to the upper surface and bottom surface of the body. The flashing can be measured as the percentage of area of the body along the side surface contained within a box extending between an innermost point of the side surface (e.g., **1631**) and an outermost point (e.g., **1632**) on the side surface of the body. In one particular instance, the body can have a particular content of flashing, which can be the percentage of area of the body contained within the boxes **1642** and **1643** compared to the total area of the body contained within boxes **1642**, **1643**, and **1644**. According to one embodiment, the percent flashing (f) of the body can be not greater than about 45%, such as not greater than about 40%, not greater than about 36%, not greater than about 30%, not greater than about 20%, not greater than about 16%, not greater than about 14%, not greater than

about 12%, or even not greater than about 10%. In still another embodiment, the percent flashing of the body can be at least about 5%, such as at least about 5.5%, at least about 6%, at least about 6.5%, at least about 7%, or even at least about 7.5%. It will be appreciated that the percent flashing of the body can be within a range between any of the above minimum and maximum percentages. Moreover, it will be appreciated that the above flashing percentages can be representative of an average percentage flashing or a median percentage flashing for a batch of shaped abrasive particles.

The percent flashing can be measured by mounting the shaped abrasive particle on its side and viewing the body at the side to generate a black and white image, such as illustrated in FIG. **16C**. A suitable program for such includes ImageJ software. The percentage flashing can be calculated by determining the area of the body **1641** in the boxes **1642** and **1643** compared to the total area of the body as viewed at the side, including the area in the center **1644** and within the boxes. Such a procedure can be completed for a suitable sampling of particles to generate average, median, and/or standard deviation values.

A batch of shaped abrasive particles according to embodiments herein may exhibit improved dimensional uniformity as measured by the standard deviation of a dimensional characteristic from a suitable sample size. According to one embodiment, the shaped abrasive particles can have a flashing variation (Vf), which can be calculated as the standard deviation of flashing percentage (f) for a suitable sample size of particles from a batch. According to one embodiment, the flashing variation can be not greater than about 5.5%, such as not greater than about 5.3%, not greater than about 5%, or not greater than about 4.8%, not greater than about 4.6%, or even not greater than about 4.4%. In one non-limiting embodiment, the flashing variation (Vf) can be at least about 0.1%. It will be appreciated that the flashing variation can be within a range between any of the minimum and maximum percentages noted above.

The shaped abrasive particles of the embodiments herein can have a height (hi) and flashing multiplier value (hiF) of at least 4000, wherein  $hiF=(hi)(f)$ , an “hi” represents a minimum interior height of the body as described above and “f” represents the percent flashing. In one particular instance, the height and flashing multiplier value (hiF) of the body can be greater, such as at least about 2000 micron %, at least about 2500 micron %, at least about 2800 micron %, at least about 3000 micron %, or even at least about 3200 micron %. Still, in one non-limiting embodiment, the height and flashing multiplier value can be not greater than about 45000 micron %, such as not greater than about 20000 micron %, not greater than about 10000 micron %, not greater than about 8000 micron %, or even not greater than about 5000 micron %. It will be appreciated that the height and flashing multiplier value of the body can be within a range between any of the above minimum and maximum values. Moreover, it will be appreciated that the above multiplier value can be representative of a median multiplier value (MhiF) for a batch of shaped abrasive particles.

The shaped abrasive particles of the embodiments herein can have a dishing (d) and flashing (F) multiplier value (dF) as calculated by the equation  $dF=(d)(F)$ , wherein dF is not greater than about 90%, wherein “d” represents the dishing value, and “f” represents the percentage flashing of the body. In one particular instance, the dishing (d) and flashing (F) multiplier value (dF) of the body can be not greater than about 70%, such as not greater than about 60%, not greater than about 50%, not greater than about 30%, not greater than about 20%, or even not greater than about 10%. Still, in one



non-limiting embodiment, the dishing (d) and flashing (F) multiplier value (dF) can be at least about 4.5%, such as at least about 6%, at least about 7%, at least about 7.5%, or even at least about 8%. It will be appreciated that the dishing (d) and flashing (F) multiplier value (dF) of the body can be within a range between any of the above minimum and maximum values. Moreover, it will be appreciated that the above multiplier value can be representative of a median multiplier value (MdF) for a batch of shaped abrasive particles.

The shaped abrasive particles of the embodiments herein can have a height and dishing ratio ( $hi/d$ ) as calculated by the equation  $hi/d=(hi)/(d)$ , wherein  $hi/d$  is not greater than about 1000, and "hi" represents a minimum interior height as described above, and "d" represents the dishing of the body. In one particular instance, the ratio ( $hi/d$ ) of the body can be not greater than about 900 microns, not greater than about 800 microns, not greater than about 700 microns, or even not greater than about 650 microns. Still, in one non-limiting embodiment, the ratio ( $hi/d$ ), can be at least about 10 microns, such as at least about 100 microns, at least about 200 microns, at least about 250 microns, at least about 300 microns, at least about 350 microns, or even at least about 375 microns. It will be appreciated that the ratio ( $hi/d$ ) of the body can be within a range between any of the above minimum and maximum values. Moreover, it will be appreciated that the above height and dishing ratio can be representative of a median height and dishing ratio (Mhi/d) for a batch of shaped abrasive particles.

The shaped abrasive particles of the embodiments herein can have a side ratio, which can be defined by  $[(w-l)/hi]$ , wherein "w" is the width or greatest dimension of the side of the particle as viewed from the side, "l" represents the length of the particle along an opposite major surface of the particle from the width as viewed from the side, and "hi" represents the interior height as described herein. In particular instances, "l" may be the profile length. According to one embodiment, the side ratio can be at least about 0.45, such as at least about 0.5, at least about 0.55, or even at least about 0.6. Still, in one non-limiting embodiment, the side ratio can be not greater than about 0.99, such as not greater than about 0.95, not greater than about 0.9, or even not greater than about 0.88. It will be appreciated that the side ratio of the body can be within a range between any of the above minimum and maximum values. Moreover, it will be appreciated that the above side ratio can be a median value, derived from median dimension values of width, length, and interior height for a batch of shaped abrasive particles.

According to another embodiment, the body can have a particular rake angle, which may be defined as an angle between the bottom surface **304** and a side surface **305**, **306** or **307** of the body. For example, the rake angle may be within a range between about  $1^\circ$  and about  $100^\circ$ . For other particles herein, the rake angle can be within a range between about  $5^\circ$  and  $100^\circ$ , such as between about  $10^\circ$  and about  $100^\circ$ , between about  $15^\circ$  and  $100^\circ$ , or even between about  $20^\circ$  and  $93^\circ$ . Formation of an abrasive particle having such a rake angle can improve the abrading capabilities of the abrasive particle. Notably, the rake angle can be within a range between any two rake angles noted above.

The shaped abrasive particle can be formed such that the body includes a crystalline material, and more particularly, a polycrystalline material. Notably, the polycrystalline material can include abrasive grains. In one embodiment, the body can be essentially free of an organic material, including for example, a binder. More particularly, the body can consist essentially of a polycrystalline material.

In one aspect, the body of the shaped abrasive particle can be an agglomerate including a plurality of abrasive particles, grit, and/or grains bonded to each other to form the body of the abrasive particle. Suitable abrasive grains can include nitrides, oxides, carbides, borides, oxynitrides, oxyborides, diamond, and a combination thereof. In particular instances, the abrasive grains can include an oxide compound or complex, such as aluminum oxide, zirconium oxide, titanium oxide, yttrium oxide, chromium oxide, strontium oxide, silicon oxide, and a combination thereof. In one particular instance, the abrasive particle is formed such that the abrasive grains forming the body **101** include alumina, and more particularly, may consist essentially of alumina.

The abrasive grains (i.e., crystallites) contained within the body may have an average grain size that is generally not greater than about 100 microns. In other embodiments, the average grain size can be less, such as not greater than about 80 microns, not greater than about 50 microns, not greater than about 30 microns, not greater than about 20 microns, not greater than about 10 microns, or even not greater than about 1 micron. Still, the average grain size of the abrasive grains contained within the body can be at least about 0.01 microns, such as at least about 0.05 microns, such as at least about 0.08 microns, at least about 0.1 microns, or even at least about 1 micron. It will be appreciated that the abrasive grains can have an average grain size within a range between any of the minimum and maximum values noted above.

In accordance with certain embodiments, the abrasive particle can be a composite article including at least two different types of abrasive grains within the body. It will be appreciated that different types of abrasive grains are abrasive grains having different compositions with regard to each other. For example, the body can be formed such that it includes at least two different types of abrasive grains, wherein the two different types of abrasive grains can be nitrides, oxides, carbides, borides, oxynitrides, oxyborides, diamond, and a combination thereof.

In accordance with an embodiment, the abrasive particle can have an average particle size, as measured by the largest dimension measurable on the body, of at least about 100 microns. In fact, the abrasive particle can have an average particle size of at least about 150 microns, such as at least about 200 microns, at least about 300 microns, at least about 400 microns, at least about 500 microns, at least about 600 microns, at least about 700 microns, at least about 800 microns, or even at least about 900 microns. Still, the abrasive particle can have an average particle size that is not greater than about 5 mm, such as not greater than about 3 mm, not greater than about 2 mm, or even not greater than about 1.5 mm. It will be appreciated that the abrasive particle can have an average particle size within a range between any of the minimum and maximum values noted above.

FIG. **17A** includes a top-down image of a shaped abrasive particle formed according to an embodiment. FIG. **17B** includes a side-view image of the shaped abrasive particle of FIG. **17A**. FIG. **17C** includes an image of a side-view of a shaped abrasive particle according to an embodiment. As depicted, the shaped abrasive particle **1700** can have a body **1701** including a first major surface (i.e., upper surface) **1702**, a second major surface (i.e., bottom surface) **1703**, and side surfaces **1704**, **1705**, and **1706** extending between the first and second major surfaces **1701** and **1702**. As further shown, the shaped abrasive particle comprises a corner-truncated two-dimensional shape as viewed top down in the plane defined by the length and width of the body **1701**. In particular, the body **1701** is a multiple corner-truncated



triangular shape having a first triangular corner 1707, a truncated corner 1708, and a partially truncated corner 1709. A corner truncated shape can include shapes wherein at least a portion of the feature of a corner is missing or altered in shape, such as the partially truncated corner 1709 of the body 1701.

As further shown in FIG. 17A, the partially truncated corner 1709 can include a bottom portion 1771 and an upper portion 1772, which can be distinct from each other in location and shape. As shown, the bottom portion 1771 can extend from the bottom surface 1703 of the body 1701. In particular, the bottom portion 1771 can extend vertically in the direction of the height of the body for a fraction of the height of the body, such that an upper surface of the bottom portion 1771 is spaced apart from the upper surface 1702 of the body 1701 by the upper portion 1772. The bottom portion 1771 can have a shape approximating the shape of the corner that may have been formed prior to partial truncation. For example, as shown, the bottom portion 1771 can have a shape as viewed top down that is substantially the same as the shape of corner 1707, which is representative of a non-truncated corner for the body 1701.

The upper portion 1772 can include a substantially flat surface extending between the side surfaces 1706 and 1705. The upper portion can be abutting the upper surface 1702, and more particularly, intersecting an edge defining a perimeter of the upper surface 1702. The upper portion 1772 can have a height extending vertically in the direction of the height of the particle for a fraction of the total height of the particle. The upper portion 1772 can extend downward from the upper surface 1702 toward the bottom surface 1703 of the body and abutting the bottom portion 1771 at a point along the corner 1709 between the upper surface 1702 and bottom surface 1703.

The corner 1708 of the body can include a completely truncated corner, wherein the entire corner 1708 is defined by a single, substantially flat surface extending between the upper surface 1702 and the bottom surface 1703 of the body.

As further shown in FIG. 17C, the body 1701 can include fractured regions 1773, 1774, and 1775. The fractured regions 1773, 1774, and 1775, may be linked to one or more aspects of the forming process, including but not limited to, sectioning of the sheet and fracture of the gel between precursor shaped abrasive particles after sectioning or partial sectioning. The fractured regions 1773 and 1774 can be preferentially located at or near the corners 1708 and 1709, respectively. In particular, the fractured region 1773 can be abutting the truncated corner 1708, and even more particularly, the fracture region 1773 can define a portion of the body 1701 extending from the bottom surface 1703 around the entire periphery of the truncated corner 1708 from side surface 1706 to side surface 1704. The fractured region 1774 can be preferentially located at the corner 1709, and particularly may extend for a distance from the corner 1709 down the width of the side surface 1706 toward the corner 1708. The fractured region 1774 can extend from the bottom surface 1703 and extend vertically for a fraction of the entire height of the side surface 1706.

The fractured region 1775 can extend along the side surface 1705. The fractured region 1775 can define a serrated edge comprising protrusions and grooves. In particular locations, the fractured region 1775 can define irregularly shaped protrusions and irregular shaped grooves extending from the bottom surface 1703. In certain instances, the serrated edge can have the appearance of a saw blade edge.

Moreover, the fractured region 1775 can have a height extending for a fraction of the height of the side surface 1705.

In certain instances, at least a portion of the fractured surface 1775 can define irregular scalloped edge. The irregular scalloped edge can have substantially arcuate-shaped grooves separated by ridges. Moreover, the irregular scalloped edge can flow downward from the upper surface 1703 along the side surface 1705 and extend outward from the side surface 1705 away from the body 1701.

The shaped abrasive particle 1700 can have a ripple feature 1710 extending along at least a portion of the side surface of the body 1701. The ripple feature 1710 may be a result of one or more aspects of the forming process. As shown in FIG. 17B, the ripple feature 1710 can define a plurality of grooves 1711 extending along at least a portion of a side surface of the body 1701. Moreover, the ripple feature 1701 can define a plurality of grooves 1711 separated by ridges 1712, wherein the ridges 1712 can define raised regions between the grooves 1711. In certain instances, the grooves 1711 can have an average width greater than an average width of the ridges 1712. In still other instances, the grooves 1711 can have an average width less than an average width of the ridges 1712. As further shown, in certain instances, the grooves 1711 can have rounded ends 1715 for at least one end proximate to one of the major surfaces of the body 1701. Moreover, the ripple feature can include a plurality of grooves 1711 and ridges 1712, wherein the width of the grooves extending in the direction of the width of the side surface can be significantly less than the width of the side surface.

According to a particular embodiment, at least one ridge can extend along the side surface of the body 1701 in a direction defined by a longitudinal axis that defines an angle within a range between about 10 degrees and about 170 degrees relative to the first major surface 1702. Referring to FIG. 17B, the longitudinal axes of three ridges 1721, 1722, and 1723 are illustrated. Moreover, each of the longitudinal axes 1721-1723 form a particular angle  $\alpha_1$ ,  $\alpha_2$ , and  $\alpha_3$  with respect to the upper surface 1702, when the shaped abrasive particle is analyzed using a light microscope and mounted on its side as shown in FIG. 17B. In certain other embodiments, the angle can be within a range between about 30 degrees and about 150 degrees, such as within a range between about 60 degrees and about 140 degrees, or even within a range between about 70 degrees and about 120 degrees. Moreover, as illustrated in FIG. 17B, a majority of the ridges defining the ripple feature 1710 can have a longitudinal axis extending at an angle within a range between about 10 degrees and about 170 degrees relative to the first major surface 1702.

According to embodiments herein, the ripple feature 1701 can extend along a majority of a width of the body 1701 on the side surface. For example, the ripple feature 1701 can extend for at least about 70%, such as at least about 80%, or even at least about 90% of the width of the body of a side surface. In still another, non-limiting embodiment, the ripple feature 1710 can extend for essentially the entire width of the body 1701 along at least one side surface.

Moreover, the ripple feature 1710 may be present on more than one side surface of the body 1701. For example, the ripple feature 1710 can extend along a majority of the external surface area the side surfaces of the body 1701. More particularly, the ripple feature 1710 can extend along substantially all side surfaces of the body 1701.

The ripple feature may have a particular height relative to the height of the body 1701. For example, the ripple feature



1701 may have a height, as defined by the longest dimension or the ripple feature in a direction parallel to the greatest height dimension (e.g., hc) of the body 1701, which can be at least a portion (e.g., a minority) of the height of the body 1701 on at least one side surface. According to one embodiment, the ripple feature can extend for at least about 10%, such as at least about 20%, at least about 30%, or even at least about 40% of the height of the body 1701. In more particular instances, the ripple feature 1710 can extend for a majority of a height of the body 1701 on at least one side surface, including for example, at least about 50%, such as at least about 60%, at least about 70%, at least about 80%, or even at least about 90% of the height of the body. In certain instances, the ripple feature 1710 can extend for essentially the entire height of at least one side surface of the body 1701.

According to another aspect, the ripple feature 1710 can extend for at least a portion of a height of the body on a majority of side surfaces of the body 1701. In certain embodiments, the ripple feature 1710 can extend for at least a portion of a height of the body 1701 on each of the side surfaces of the body 1701.

The side surface comprising the ripple feature can have a surface roughness greater than a surface roughness of the first major surface 1702 or second major surface 1703 of the body 1701. In particular, as illustrated in views of FIGS. 17A and 17B, the side surface having the ripple feature 1710 can have a surface roughness greater than a surface roughness of an upper surface 1702 of the body 1701, wherein the upper surface 1702 of the body 1701 has striations 1731. The striations 1731 may be smoothing lines, which were initially made in an upper surface of the sheet 111 during forming, for example, via a doctor blade, which can be imparted to the shaped abrasive particles.

In certain instances, the ripple feature 1710 can intersect an edge defining a first major surface 1702 of the body 1701. More particularly, a majority of the ripple feature 1710 along the side surface of the body 1701 can intersect an upper surface 1702 of the body 1701. Still, more particularly, essentially the entire ripple feature 1710 can intersect an edge defining an upper surface 1702 of the body 1701. Moreover, at least a portion of the ripple feature 1710 can be spaced apart from a non-intersecting a bottom surface 1703 of the body 1701.

FIG. 17C includes a side-view image of a shaped abrasive particle formed according to an embodiment. As shown, the body 1751 of the shaped abrasive particle has a side surface 1757, and at least a portion of the side surface 1757 includes a fractured region 1755. The fractured region 1755 can be distinct from the ripple feature 1754, which can be characterized by grooves and ridges extending in a particular manner relative to the major surface 1752. The fracture region 1755 can be distinct from the ripple feature 1754 in its placement, orientation, and appearance on the side surface 1757. For example, the fractured region 1755 can intersect an edge defining the second major surface (i.e., bottom surface) 1753 of the body 1751. In particular instances, a majority of the fractured region can intersect the bottom surface 1753 of the body 1751. Even more particularly, in some shaped abrasive particles, essentially the entirety of the fractured region 1755 can intersect a bottom surface 1753 of the body 1701.

The fractured region 1755 can have a surface roughness that is greater than a surface roughness of the first major surface 1702 or second major surface 1703 of the body 1701. In particular instances, the fractured region 1755 can define a region having a surface roughness greater than a

surface roughness of an upper surface 1702 of the body 1701 or bottom surface 1703 of the body 1701. Moreover, the fractured region 1755 can define a region having a surface roughness greater than a surface roughness of a side surface spaced apart from the fracture region, and more particularly, a surface roughness greater than a surface roughness of the side surface including a ripple feature 1710.

As further illustrated, for shaped abrasive particles having a ripple feature 1754 and a fractured region 1755 on the same side surface 1757, the ripple feature 1754 and fractured region 1755 can be separated by a boundary 1756, which may be a region characterized by a substantially smooth surface. Moreover, in such particles, the fractured region 1755 can be abutting the edge of the body 1751 defining the bottom surface 1753 while the ripple feature 1754 can be abutting an edge of the body 1751 defining the upper surface 1752.

According to one embodiment, for certain shaped abrasive particles, the fractured region 1755 may extend for a minority of a width of the body on the side surface. In still other embodiments, the fractured region 1755 can extend along a majority of a width of the body on the side surface. Even more particularly, for certain shaped abrasive particles, the fractured region 1755 can extend for at least about 70%, such as at least about 80%, or even at least about 90% of the width of the body on a side surface. In certain instances, the fractured region can extend for essentially the entire width of the body along the entire side surface.

For certain shaped abrasive particles, the fractured region can extend along a minority of the external surface area of all side surfaces of the body. Still, for another aspect, the fractured region may extend along a majority of all side surfaces of the body. And in yet other instances, the fractured region can extend along essentially all of the side surfaces of the body.

Moreover, the fractured region 1755 can have a height (hfr) that is at least a portion of the greatest height (e.g., hc) of the body on at least one side surface. The height of the fracture region (hfr) can be the greatest dimension in the direction parallel to the height of the body 1751. According to one embodiment, the fractured region 1755 can have a height (hfr) extending for a minority of a height of the body 1751 on at least one side surface 1757. In other instances, the fractured region can have a height (hfr) extending for a majority of a height of the body 1751 on at least one side surface 1757. It will be appreciated that such features may exist for any side surfaces of shaped abrasive particles according to embodiments herein. Moreover, such features may exist for one, a minority fraction, or even a majority of shaped abrasive particles of a batch according to embodiments herein.

Embodiments herein also include a batch of particulate material, which can include one or more shaped abrasive particles of the embodiments herein. Moreover, the batch of particulate material can include shaped abrasive particles having one or more features described herein. One or more features of the shaped abrasive particles described herein can be evident in the shaped abrasive particles of a batch. Moreover, the batch may be characterized by the existence and variance of the one or more features.

According to one aspect, a batch of particulate material can include a first portion including a first type of shaped abrasive particle and a second portion including a second type of shaped abrasive particle. The content of the first portion and second portion within the batch may be controlled at least in part based upon certain processing parameters. The first portion may include a plurality of shaped



abrasive particles, wherein each of the particles of the first portion can have substantially the same two-dimensional shape.

The batch may include various contents of the first portion. For example, the first portion may be present in a minority amount or majority amount. In particular instances, the first portion may be present in an amount of at least about 1%, such as at least about 5%, at least about 10%, at least about 20%, at least about 30%, at least about 40%, at least about 50%, at least about 60%, at least about 70%, at least about 80%, or even at least about 90% for the total content of portions within the batch. Still, in another embodiment, the batch may include not greater than about 99%, such as not greater than about 90%, not greater than about 80%, not greater than about 70%, not greater than about 60%, not greater than about 50%, not greater than about 40%, not greater than about 30%, not greater than about 20%, not greater than about 10%, not greater than about 8%, not greater than about 6%, or even not greater than about 4% of the total portions within the batch. The batch can include a content of the first portion within a range between any of the minimum and maximum percentages noted above.

The second portion can include a plurality of shaped abrasive particles, wherein each of the shaped abrasive particles of the second portion can have substantially the same type of two-dimensional shape, but a distinct type of shape compared to the plurality of shaped abrasive particles of the first portion.

In certain instances, the batch may include a lesser content of the second portion relative to the first portion, and more particularly, may include a minority content of the second portion relative to the total content of particles in the batch. For example, the batch may contain a particular content of the second portion, including for example, not greater than about 40%, such as not greater than about 30%, not greater than about 20%, not greater than about 10%, not greater than about 8%, not greater than about 6%, or even not greater than about 4%. Still, in at least on non-limiting embodiment, the batch may contain at least about 0.5%, such as at least about 1%, at least about 2%, at least about 3%, at least about 4%, at least about 10%, at least about 15%, or even at least about 20% of the second portion for the total content of portions within the batch. It will be appreciated that the batch can contain a content of the second portion within a range between any of the minimum and maximum percentages noted above.

Still, in an alternative embodiment, the batch may include a greater content of the second portion relative to the first portion, and more particularly, can include a majority content of the second portion for the total content of particles in the batch. For example, in at least one embodiment, the batch may contain at least about 55%, such as at least about 60% of the second portion for the total portions of the batch.

In certain instances, the first type of shaped abrasive particle of the first portion can have a two-dimensional shape as viewed in a plane defined by a length (l) and a width (w) selected from the group of polygons, ellipsoids, numerals, Greek alphabet letters, Latin alphabet letters, Russian alphabet characters, complex shapes including a combination of polygonal shapes, and a combination thereof. For at least one particular embodiment, the first type of shaped abrasive particle of the first portion can be a triangular two-dimensional shape. The first portion may be, but need not be, essentially free of corner-truncated shapes.

The second portion can include a corner-truncated shape, including for example, a corner-truncated polygonal shape. In one particular embodiment, the second portion can

include corner-truncated triangular shapes, and may consist essentially of corner-truncated triangular shapes. It will be appreciated that the batch can include other portions, including for example a third portion, comprising a plurality of shaped abrasive particles having a third type of two-dimensional shape that is different than the two-dimensional shape of the first type and second type of shaped abrasive particles. For example, in one particular embodiment, the batch can include a first portion comprising a plurality of shaped abrasive particles having a triangular two-dimensional shape, a second portion including a plurality of shaped abrasive particles having a single corner-truncated polygonal shape (e.g., a single corner-truncated triangular shape), and a third portion comprising a multiple (i.e., more than one) corner-truncated polygonal shape (e.g., corner-truncated triangular shapes having two or three corners truncated). Still, the second portion may include single corner-truncated shapes and multiple (i.e., more than one) corner-truncated shapes. For example, at least 10% of the second portion can include multiple corner-truncated triangle shapes having more than one truncated corner.

The batch may include various contents of the third portion relative to the second portion and first portion. The third portion may be present in a minority amount or majority amount. In particular instances, the third portion may be present in an amount of not greater than about 40%, such as not greater than about 30%, not greater than about 20%, not greater than about 10%, not greater than about 8%, not greater than about 6%, or even not greater than about 4% of the total portions within the batch. Still, in other embodiments the batch may include a minimum content of the third portion, such as at least about 1%, such as at least about 5%, at least about 10%, at least about 20%, at least about 30%, at least about 40%, or even at least about 50%. The batch can include a content of the third portion within a range between any of the minimum and maximum percentages noted above. Moreover, the batch may include a content of diluent, randomly shaped abrasive particles.

The batch may further include other features. For example, one or more shaped abrasive particles of the portions of the batch can have features of embodiments herein. In one instance, at least one shaped abrasive particle of the first portion can have a ripple feature on at least a portion of a side surface of the body of the particle. In other instances, a majority of shaped abrasive particles of the first portion can have a ripple feature on at least one side surface. In yet another aspect, essentially all of the shaped abrasive particles of the first portion can have a ripple feature on at least one side surface.

Moreover, at least one shaped abrasive particle of the second portion can include a ripple feature on at least a portion of a side surface. In yet another embodiment, a majority of shaped abrasive particles of the second portion can have a ripple feature on at least one side surface of each body. In still yet another aspect, essentially all of the shaped abrasive particles of the second portion may have a ripple feature on at least one side surface of each body.

Another aspect of the batch can be that at least one shaped abrasive particle of the first portion may have a fractured region on at least a portion of a side surface. For other embodiments, a majority of shaped abrasive particles of the first portion, including for example, essentially all of the shaped abrasive particles of the first portion, may have a fractured region on at least one side surface. Additionally or alternatively, at least one shaped abrasive particle of the second portion can include a fractured region on at least a portion of a side surface. More particularly, a majority of



shaped abrasive particles of the second portion, and even essentially all of the shaped abrasive particles of the second portion, can include a fractured region on at least one side surface of each body.

At least one shaped abrasive particle of the first portion can have a side surface having a surface roughness greater than a surface roughness of a first major surface of the corresponding body. In still other instances, a majority of the shaped abrasive particles of the first portion, including essentially all of the shaped abrasive particles of the first portion, can have at least one side surface having a surface roughness greater than a surface roughness of the first major surface (e.g., an upper surface) for each of the corresponding bodies.

Likewise, at least one shaped abrasive particle of the second portion can have a side surface having a surface roughness greater than a surface roughness of a first major surface of the corresponding body. In one particular embodiment, a majority of the shaped abrasive particles of the second portion, including essentially all of the shaped abrasive particles of the second portion, can have at least one side surface having a surface roughness greater than a surface roughness of the first major surface for each of the corresponding bodies.

As will be appreciated, the batch can be part of a fixed abrasive article, including exemplary abrasive articles described herein. Moreover, according to certain embodiments, batch of particulate material may be incorporated into the fixed abrasive article in a predetermined orientation, wherein each of the shaped abrasive particles can have a predetermined orientation relative to each other and relative to a portion of the abrasive article (e.g., the backing of a coated abrasive).

#### EXAMPLES

A mixture in the form of a gel is obtained having approximately 52% solids loading of boehmite commercially available as Catapal B from Sasol Corp. combined with 48 wt % water containing a minority content of nitric acid and organic additives. The gel has a viscosity of approximately  $8 \times 10^4$  Pa s and a storage modulus of  $5 \times 10^5$  Pa, wherein viscosity is calculated by dividing the storage modulus value by  $6.28 \text{ s}^{-1}$ .

The gel is extruded from a die at approximately 80 psi (552 kPa) onto a translating belt having a film of polyester. The gel travels under a knife edge of the die to form a sheet having a height of approximately 1 mm. Within 10 minutes of extruding, the sheet is sectioned using a blade at ambient atmospheric conditions, in air, and at a temperature of approximately 72° F. to form precursor shaped abrasive particles. The openings are maintained using an air knife directing air at the openings formed by the blade. The precursor shaped abrasive particles are dried for approximately 1-4 hours and fired at a temperature of approximately 1200° C.-1400° C. for 15 minute to 1 hour in air.

The shaped abrasive particles of Example 1 were formed and analyzed. FIGS. 17A and 17B include an image of a representative particle formed according to Example 1. FIGS. 18A-18E include images of other exemplary shaped abrasive particles formed according to Example 1. Moreover, FIGS. 19A-19E include images of the sides of the shaped abrasive particles of FIGS. 18A-18E, respectively. The batch of shaped abrasive particles have a median width of 1.53 mm, a median interior height of 451 microns, a median dishing ratio of 1.05 microns, a side ratio of 0.71, and a percent flashing of approximately 8%. Approximately

60% of the abrasive particles of the batch had at least one truncated corner, and a majority of the corner-truncated triangles were multiple corner-truncated shapes. Approximately 40% of the particles of the batch had at least one partially truncated corner. Furthermore, as demonstrated in the images, all of the shaped abrasive particles had at least one side surface having a ripple feature. Moreover, a significant portion of the shaped abrasive particles had at least one side surface having a fracture region. Moreover, a majority of shaped abrasive particles demonstrated at least one side surface having a fractured region defined by a serrated edge extending from the bottom surface and/or an irregular scalloped edge.

The present application represents a departure from the state of the art. While the industry has recognized that shaped abrasive particles may be formed through processes such as molding and screen printing, the processes of the embodiments herein are distinct from such processes. Notably, the embodiments herein utilize a combination of process features that facilitate the formation of shaped abrasive particles having one or a combination of unique features. Such features can include, but are not limited to, aspect ratio, composition, additives, two-dimensional shape, three-dimensional shape, difference in height, difference in height profile, flashing percentage, interior height, dishing, side ratio, fractured regions, ripple feature, and other aspects of the embodiments herein. Moreover, the processes of the embodiments herein facilitate the formation of a shaped abrasive particle or a batch of shaped abrasive particles, having one or more characteristics, including one or more combination of the features of the shaped abrasive particles. Certain shaped abrasive particles and batches containing shaped abrasive particles of the embodiments herein may have features that enable enhanced performance in the context of fixed abrasive articles. And in fact, and quite unexpectedly, such compositions may facilitate improved grinding performance in the context of fixed abrasives, such as bonded abrasives or coated abrasives.

The above-disclosed subject matter is to be considered illustrative, and not restrictive, and the appended claims are intended to cover all such modifications, enhancements, and other embodiments, which fall within the true scope of the present invention. Thus, to the maximum extent allowed by law, the scope of the present invention is to be determined by the broadest permissible interpretation of the following claims and their equivalents, and shall not be restricted or limited by the foregoing detailed description.

The Abstract of the Disclosure is provided to comply with Patent Law and is submitted with the understanding that it will not be used to interpret or limit the scope or meaning of the claims. In addition, in the foregoing Detailed Description, various features may be grouped together or described in a single embodiment for the purpose of streamlining the disclosure. This disclosure is not to be interpreted as reflecting an intention that the claimed embodiments require more features than are expressly recited in each claim. Rather, as the following claims reflect, inventive subject matter may be directed to less than all features of any of the disclosed embodiments. Thus, the following claims are incorporated into the Detailed Description, with each claim standing on its own as defining separately claimed subject matter.

What is claimed is:

1. A particulate material comprising:

a shaped abrasive particle having a body comprising a corner-truncated polygonal shape including a first side, a second side, and a third side disposed between the first side and second side, wherein the third side has a



width shorter than a width of the first side and shorter than a width of the second side, wherein the body has a first angle between the third side and the first side greater than  $90^\circ$ , wherein the body is essentially free of a binder, and wherein the body comprises a corner truncated quadrilateral two-dimensional shape.

2. The particulate material of claim 1, wherein the third side comprises a width of not greater than about 60% and at least about 2% of the width of the first side.

3. The particulate material of claim 1, wherein the particulate material is part of a batch of particulate material and defines a first type of abrasive particle having a first polygonal shape, and wherein the batch includes a second type of abrasive particle having a different polygonal shape with respect to the first type of abrasive particle, and wherein the batch comprises:

a first type of shaped abrasive particle and a second type of shaped abrasive particle, and wherein the first type of shaped abrasive particle comprises the corner-truncated shaped abrasive particle having a length (l), the width of the first side (w), and a height (h), and wherein the first type of shaped abrasive particle comprises a first polygonal shape as viewed in a plane defined by the length and width; and

a second type of shaped abrasive particle comprising a length (l), a width (w), and a height (h), wherein the second type of shaped abrasive particle comprises a second polygonal shape as viewed in a plane defined by the length and width, the second polygonal shape being different than the first polygonal shape.

4. The particulate material of claim 1, wherein the body comprises the width of the first side (w), a length (l), and a height (h), wherein the width > length, the width > height, and the length > height, and wherein a side surface defines a height of the body.

5. The particulate material of claim 1, further comprising a ripple feature extending along at least a portion of at least one side surface of the body.

6. The particulate material of claim 1, wherein the particulate material is incorporated in a fixed abrasive article.

7. The particulate material of claim 1, wherein the body comprises a ceramic material comprising an oxide, a nitride, a carbide, a boride, an oxycarbide, an oxynitride, or a combination thereof.

8. The particulate material of claim 1, wherein the width of the first side is at least equal to the width of the second side.

9. The particulate material of claim 1, further comprising a second angle between the third side and the second side greater than  $90^\circ$ .

10. The particulate material of claim 9, wherein the first angle is the same as the second angle.

11. The particulate material of claim 9, wherein the first angle is different than the second angle.

12. The particulate material of claim 1, further comprising a fourth side, wherein the fourth side has a width that is at least equal to the width of the first side.

13. The particulate material of claim 12, further comprising a fifth side between the first side and the fourth side.

14. The particulate material of claim 1, wherein the body comprises an additive selected from the group consisting of alkali elements, alkaline earth elements, rare-earth elements, hafnium (Hf), zirconium (Zr), niobium (Nb), tantalum (Ta), molybdenum (Mo), and a combination thereof.

15. The particulate material of claim 1, wherein the body further comprises a first major surface, a second major surface, and a side surface extending between the first major surface and second major surface, wherein the side surface comprises a fractured region.

16. The particulate material of claim 15, wherein the fractured region intersects the second major surface of the body.

17. The particulate material of claim 15, wherein the fractured region has a height extending for a majority of a height of the body on at least one side surface.

18. The particulate material of claim 15, wherein the fractured region extends along a majority of the side surface of the body.

19. The particulate material of claim 15, wherein the fractured region abuts a truncated corner of the body.

20. The particulate material of claim 15, wherein the fractured region defines a serrated edge comprising protrusions and grooves.

\* \* \* \* \*